

**U.S. ARMY WEAPONS COMMAND
DEPOT MAINTENANCE WORK INSTRUCTIONS
FOR
Overhaul Of The Machine Guns, 7.62MM:
M60 And M60C**



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ROCK ISLAND ARSENAL
ROCK ISLAND, ILLINOIS 61201

Turrell/dc/5470

IN REPLY REFER TO

AMSWE-SMM-SA

29 June 1967

SUBJECT: Repair of Butt Stock M60 Machine Gun USAWECOMDMWI
1005-224 Change #8

TO: See Distribution

Remove from subject DMWI, Figure 31 and all associated illustrations of Change #3. Insert new legend and Figures 31 through 31F.

FOR THE COMMANDER:

6 Incl
as

George R. Young
GEORGE R. YOUNG
Chief, Small Arms Division
National Maintenance Point

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SUGGESTED PROCEDURE

REPAIR OF M60 MACHINE GUN BUTT STOCK ASSEMBLIES

1. Remove butt stock assembly. Refer to TM 9-1005-224-34, Chapter 5, Section IV.
2. Remove rivets securing the butt stock plate assembly as follows:
 - a. Center punch rivet heads on left side of butt stock.
 - b. Drill through rivet heads (use 1/8 inch drill).
 - c. Punch out rivets.
3. Remove shoulder rest assembly.
4. Remove butt stock plate assembly from butt stock frame.
5. Fabricate (2) reinforcing plates in accordance with Figure 31.
6. Locate (4) .192 + .005 diameter holes as indicated in Figure 31A. Drill through from each side. (Use No. 10 drill). Suggest reinforcing block of approximately 1.500 inch height be used between sides of butt stock frame during drilling and spot facing operations to avoid distortion caused by pressure.
7. Spotface (4) locations, to required 3/8 inch diameter. Exercise care to remove only rubber coating. (See Figure 31A).
8. Assemble as shown in Figure 31B. Clamp plates securely in location.
9. Drill (4) .195 + .005 inch diameter holes, two from each side, through fabricated plates using holes drilled in operation to above as a guide. (See Figure 31B. Note suggested separator block of approximate 1.400 inch height).
10. Remove all burs and drilling chips.
11. Rivet fabricated plates to butt stock frame using (4) rivets FSN 5320-242-1582, Part No. MS 20470A6-4. Care must be exercised to avoid damage to or distortion of material being riveted (See Figure 31C).
12. Assemble butt stock plate assembly to butt stock frame, realining the original rivet holes. Using butt stock plate assembly as a guide, drill (2) .127 + .005 inch holes (No. 30 drill), through the top fabricated plate. Turn complete assembly over and repeat operation for second plate. Disassemble and remove all burs and drilling chips. (See Figure 31D).

13. Place shoulder rest in butt stock plate assembly. Install in butt stock frame and rivet in location. (See Figures 31E and 31F).

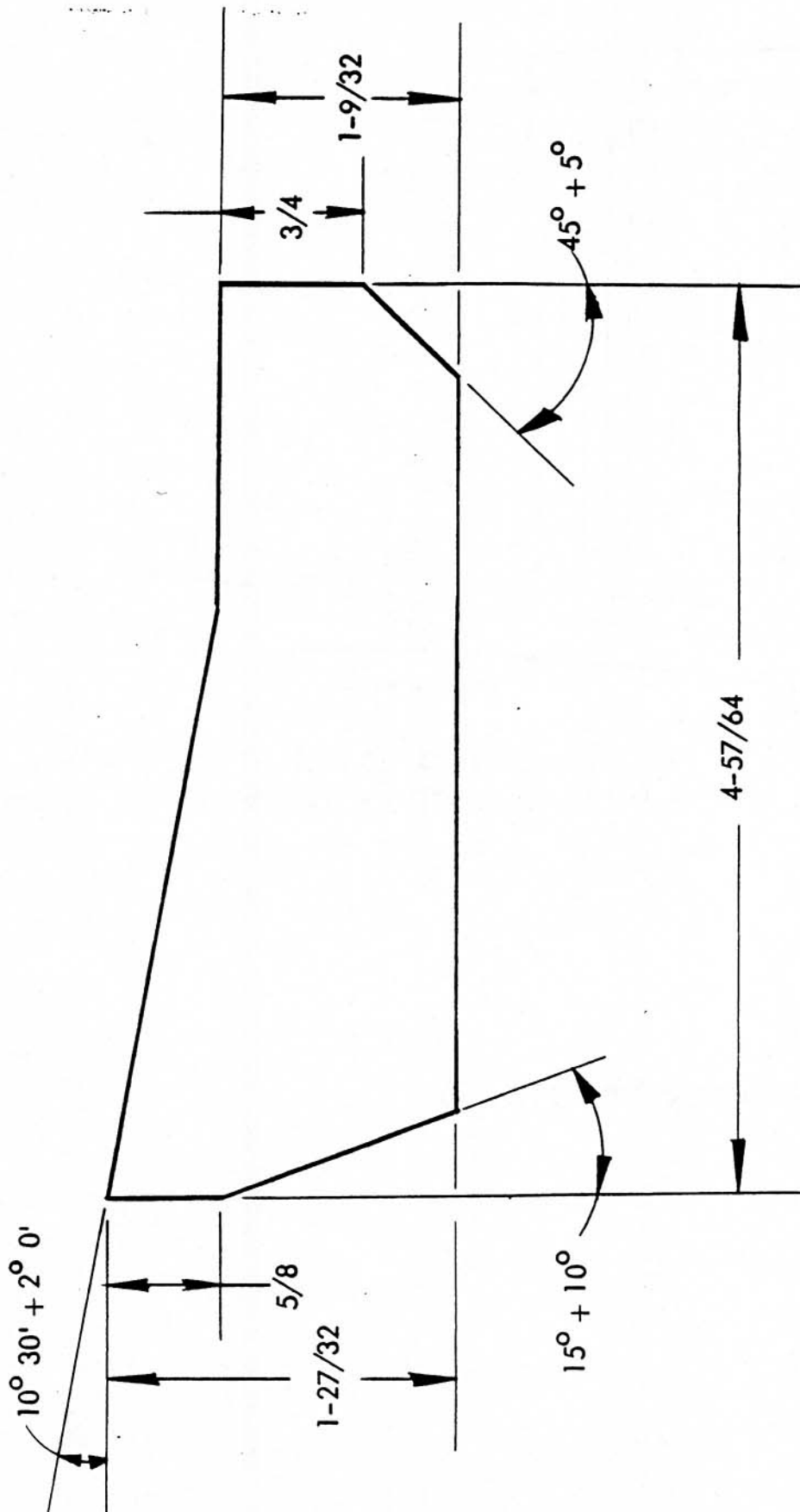
14. Touch up rivets and bright areas with dark gray or black quick drying synthetic primer or lacquer. Material used must be one that is unaffected by preservatives and cleaners used with this item. (Suggest Lacquer, Black (jet) lusterless, Type I, color 37038, Spec. TT-L-50D, Type I, nitro cellulose base).

15. Install butt stock assembly. Refer to TM 9-1005-224-34, Chapter 5, Section IV.

LEGEND

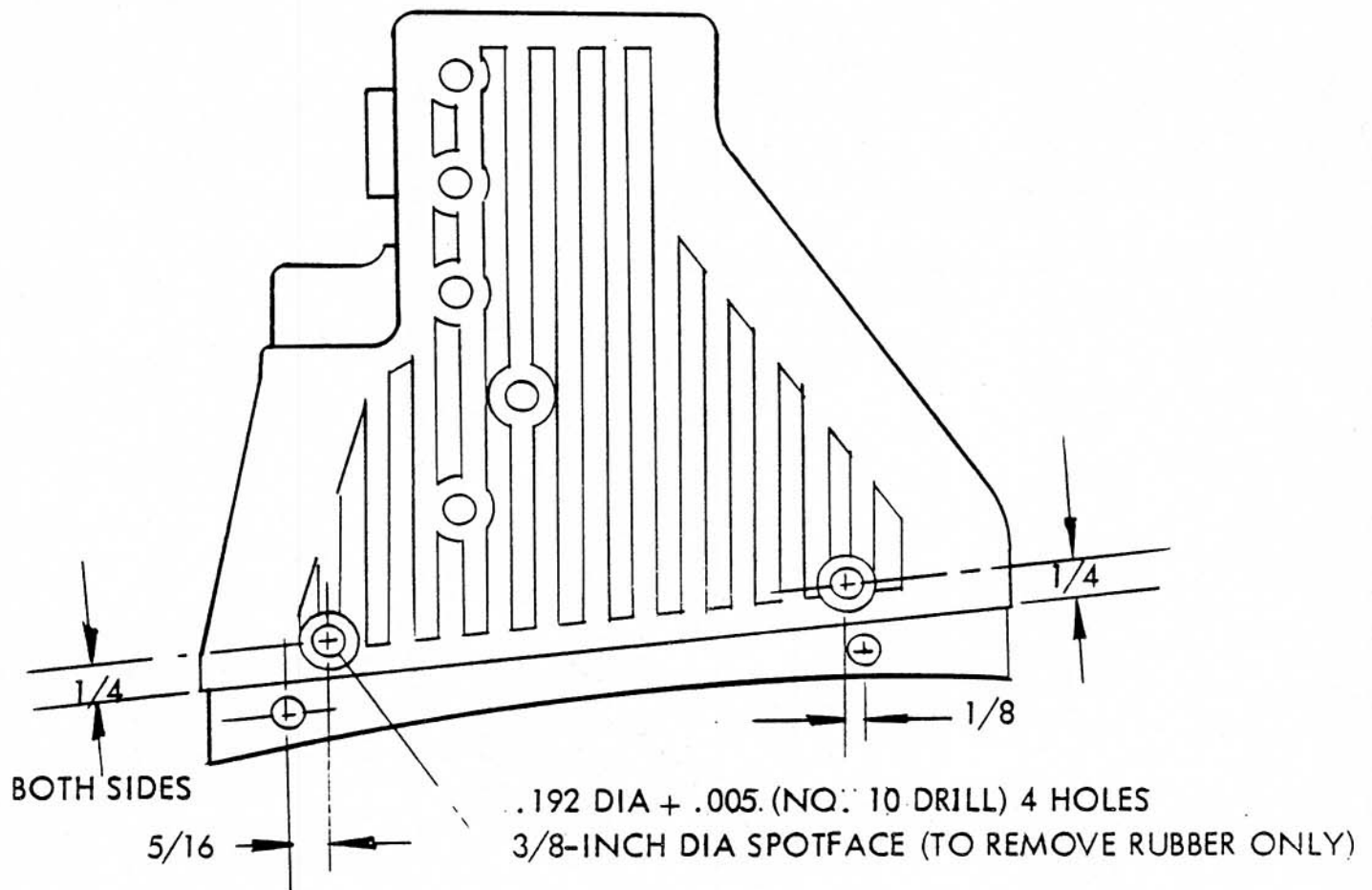
FIGURES 31 through 31F

NOTE: ALL DIMENSIONS SHOWN ARE IN INCHES.



USAWECOMDMWI 1005-224
Change #8

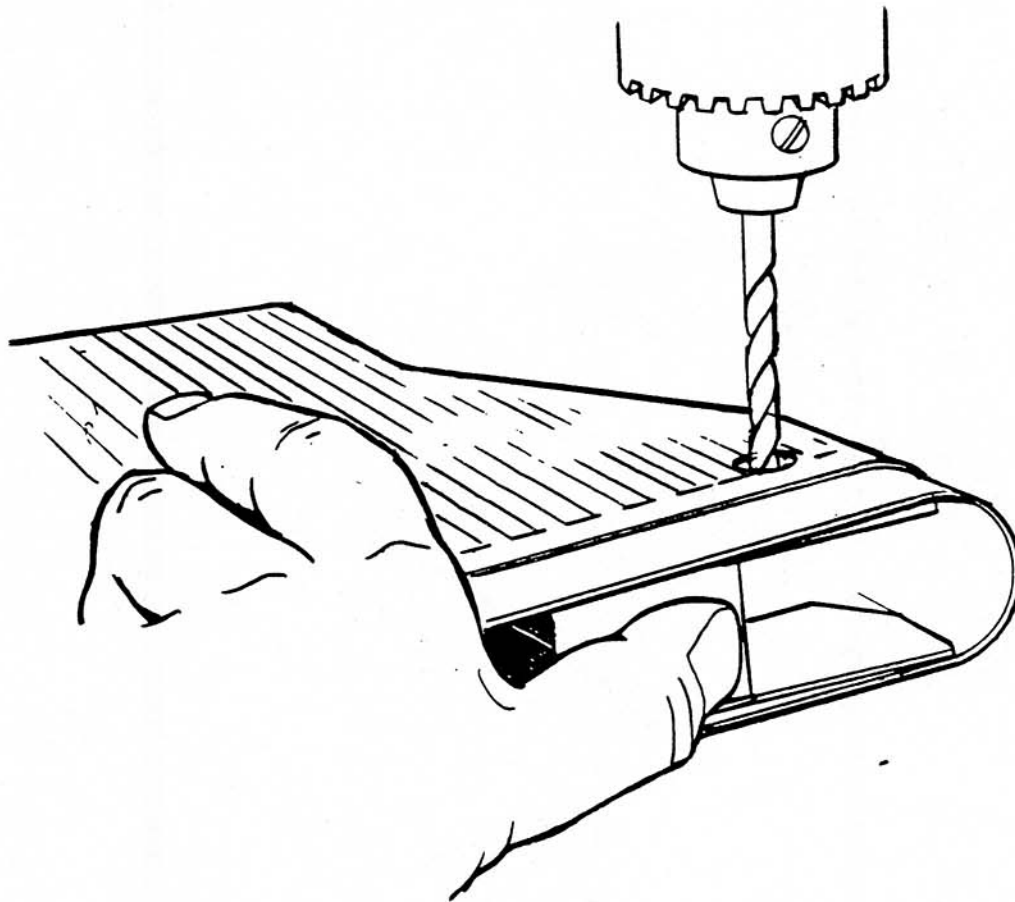
MATERIAL: 18 GAGE STEEL STRIP CR 1010-1020 (FED SPEC QQ-S-698)
PROTECTIVE FINISH: PHOSPHATE COATING WITH TYPE M OR TYPE Z,
CLASS 1 OF MIL-P-16232



TOLERANCE EXCEPT AS NOTED $\pm 1/32$

FIGURE 31A

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USING HOLES IN BUTT STOCK FRAME FOR A GUIDE, DRILL (2) $.192 + .005$ INCH DIAMETER HOLES (NO. 10 DRILL), THROUGH THE UPPER PLATE ONLY. TURN ENTIRE ASSEMBLY OVER AND REPEAT PROCESS FOR THE REQUIRED (2) HOLES ON THE OTHER SIDE. DURING DRILLING IT IS SUGGESTED THAT A SEPARATOR BLOCK OF APPROPRIATE HEIGHT (APPROXIMATELY 1.400 INCH), BE PLACED BETWEEN THE FABRICATED PLATES TO AVOID DISTORTION CAUSED BY PRESSURE DURING DRILLING.

FIGURE 31B

USAWECOMDMWI 1005-224
Change #8

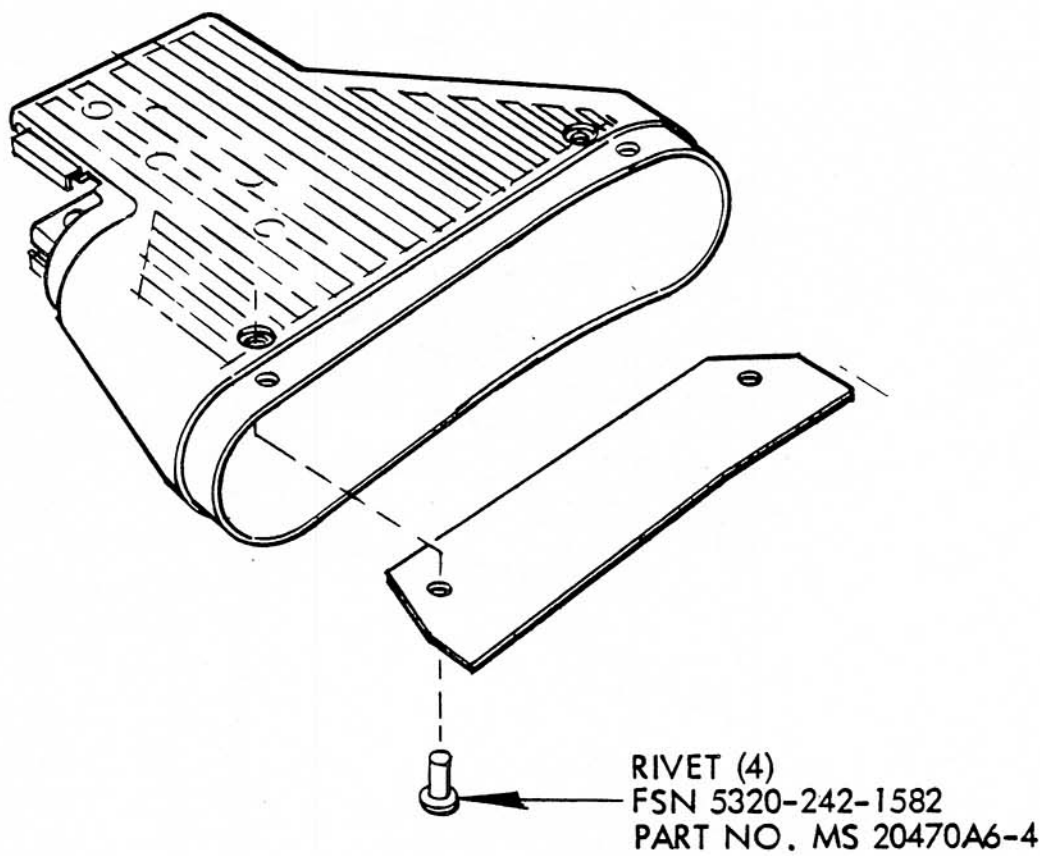
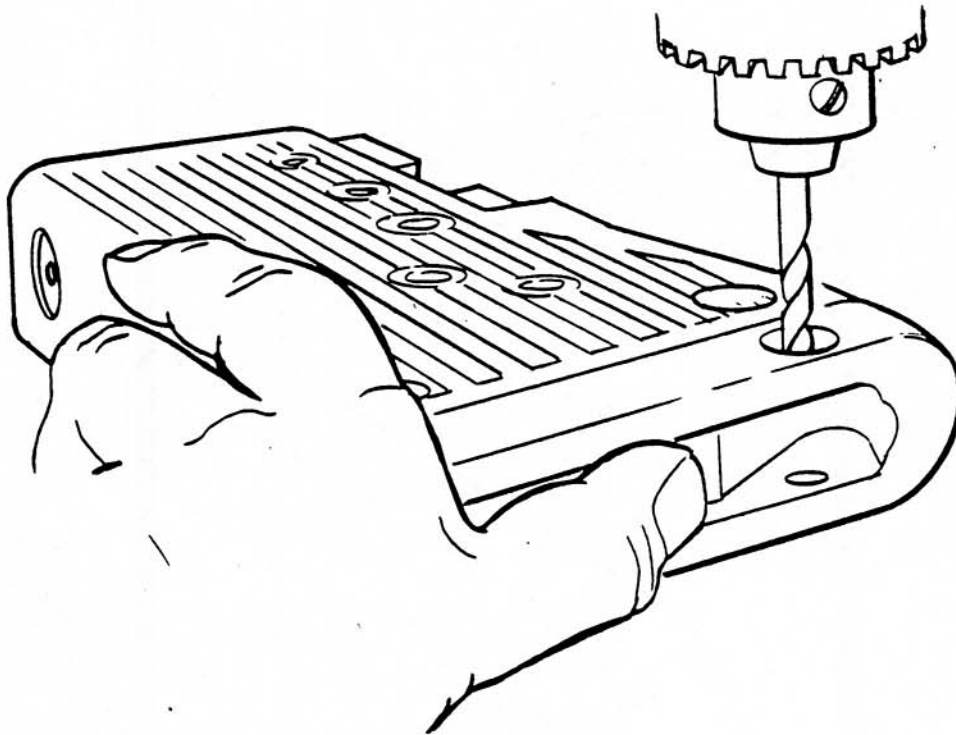


FIGURE 31C



USING BUTT STOCK PLATE ASSEMBLY HOLES FOR A GUIDE, DRILL (2) $.127 + .005$ DIAMETER HOLES (NO. 30 DRILL), THROUGH TOP FABRICATED PLATE. TURN ENTIRE ASSEMBLY OVER AND REPEAT PROCESS FOR THE REQUIRED (2) HOLES IN THE OTHER FABRICATED PLATE.

FIGURE 31D

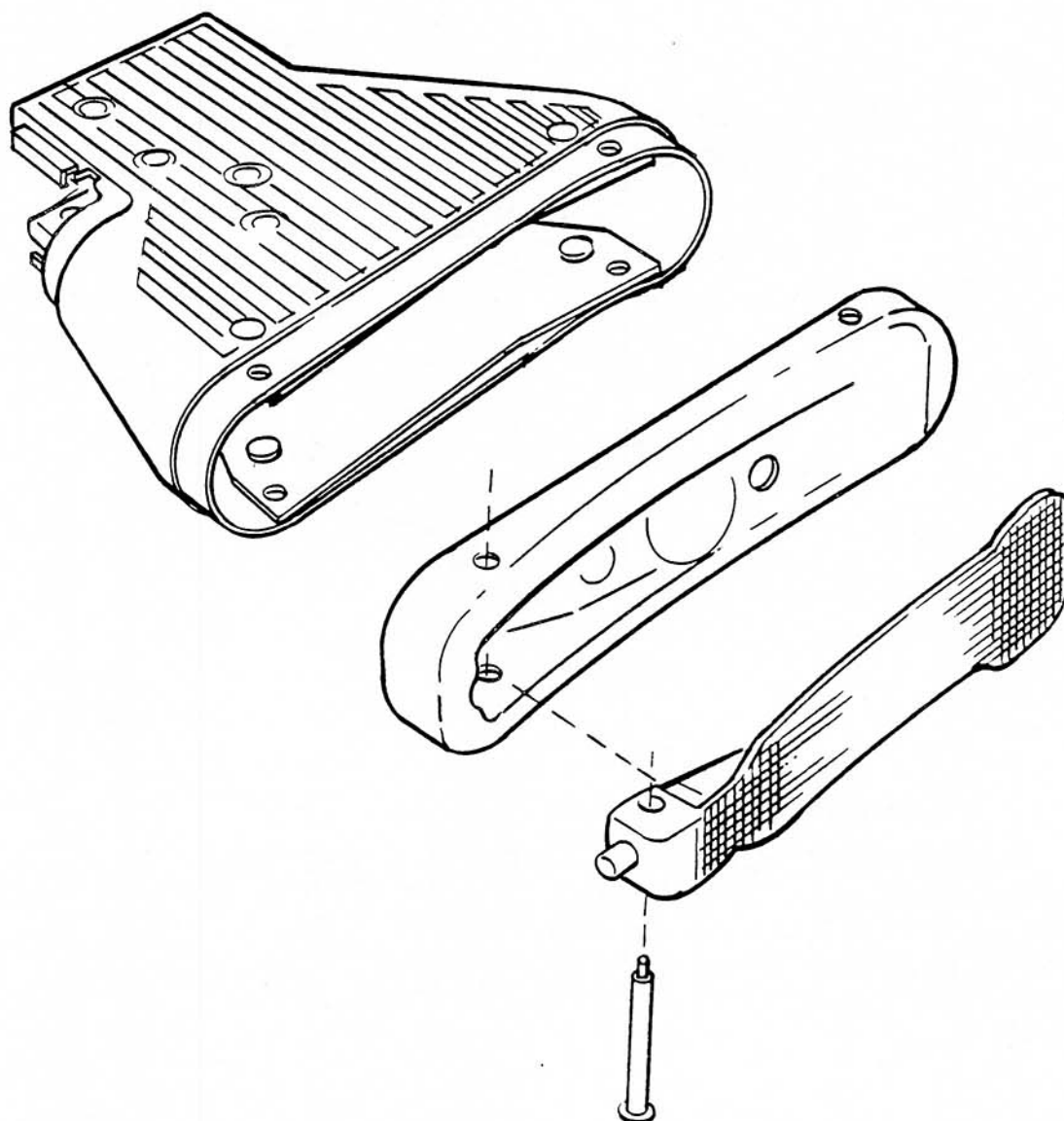


FIGURE 31E

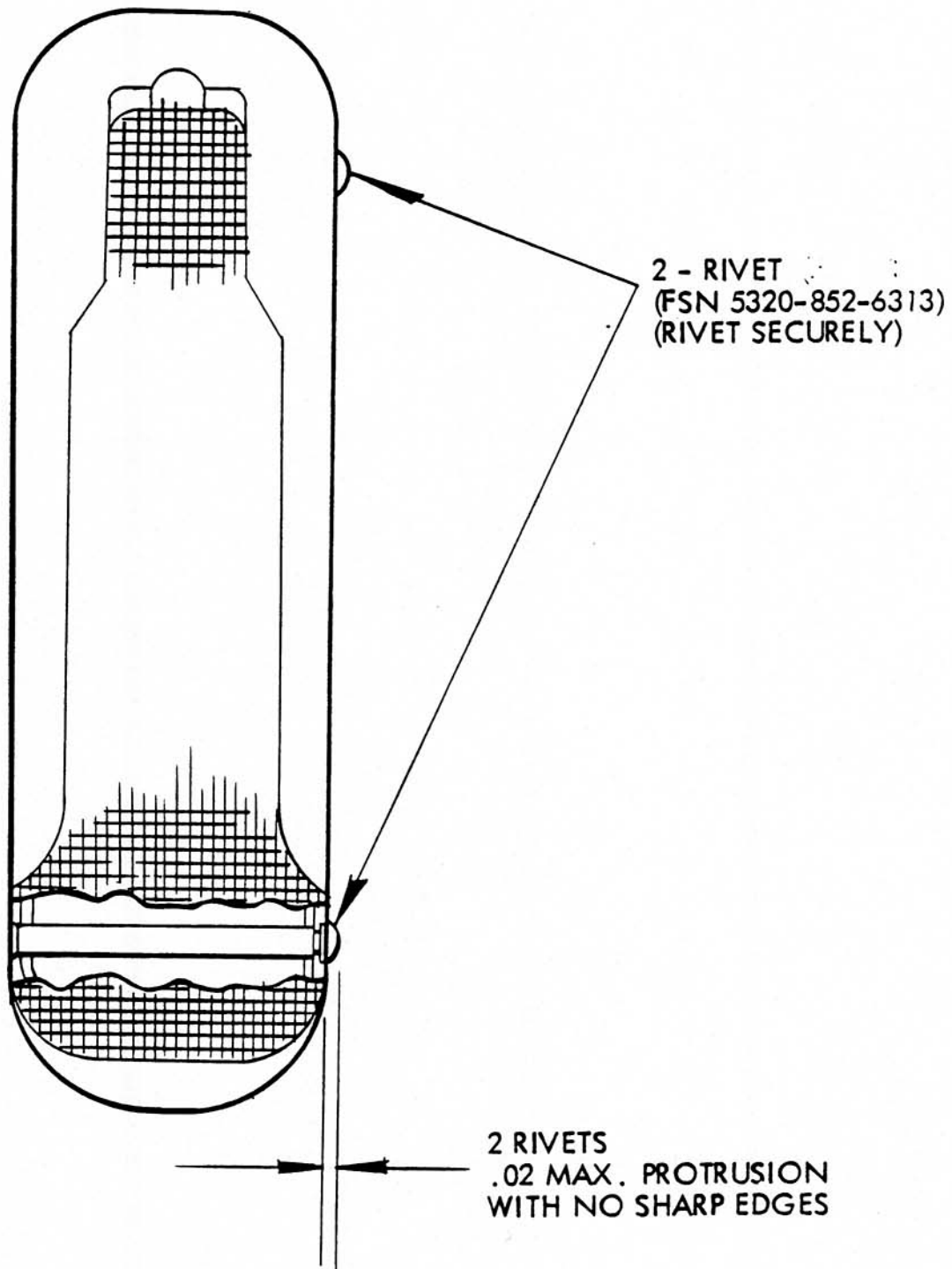


FIGURE 31F



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ROCK ISLAND, ILLINOIS 61201

Turrell/dc/5470

IN REPLY REFER TO:

AMSWE - SMM-SA

31 October 1966

SUBJECT: Change #6 to DMWI 1005-224 dated May 1965
(7.62MM Machine Gun M60 and M60C)

TO: SEE DISTRIBUTION

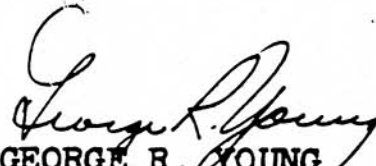
1. Paragraph 6.9.6.3.5 (b) is considered restrictive pertaining to Machining Method of application of underput required by OIP7269199. (Reference Figure 44 also).

2. Pen and ink change shall be made to above paragraph as follows:

Remove: "Using a 3/16 inch two lip end mill."

Add at sentence end: "Machining Method optional".

FOR THE COMMANDER:


GEORGE R. YOUNG
Chief, Small Arms Division
National Maintenance Point



DEPARTMENT OF THE ARMY
HEADQUARTERS, UNITED STATES ARMY WEAPONS COMMAND
ROCK ISLAND ARSENAL
ROCK ISLAND, ILLINOIS 61202

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IN REPLY REFER TO:

AMSWE - SMM

17 March 1966

SUBJECT: USAWECOMDMWI 1005-224, Change 4

F.1c
1

TO: SEE DISTRIBUTION

MAY 23 RECD

1. Targeting and accuracy testing of M60, M60C, and M60D Machine Guns will not be required during overhaul.
2. Delete the following from Subject DMWI:
 - ✓a. Page 13, para. 3.8.
 - ✓b. Page 13, para. 3.8.1.
 - ✓c. Page 14, Table 1 and instructions 1 and 2.
 - d. Page 14, para. 3.8.2.
 - ✓e. Page 14, Table 2 and instructions 1 and 2.
 - ✓f. Page 31, para. 4.4.3.2: remove targeting and accuracy firing testing.
 - ✓g. Page 31, para. 4.4.3.2.1: remove all reference of targeting and accuracy from this paragraph.
 - ✓h. Page 32, para. 4.4.3.2.2: same as g above.
 - ✓i. Page 36, para. 4.5.5.
 - ✓j. Page 36, para. 4.5.5.1.1.
 - ✓k. Page 36 and 37, para. 4.5.5.1.2.
 - ✓l. Page 37, para. 4.5.5.1.4.
3. Add new para. 4.5.5.1.4: After boresighting (see 4.5.5.2.1) the rear sight base shall be staked in place and the adjustable elevation scale shall be set at the correct scale graduation.

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✓4. Function and reliability tests shall be done with slave barrels.

5. The following paragraphs will be deleted or changed:

✓a. Page 34, para. 4.5.3, line 5: change the comma after "damage" to a period, and delete the rest of the sentence.

✓b. Page 35, table IV: M60 functioning firing test schedule shall be changed to the following:

	Each Machine Gun	Type of Firing
Slave Barrel	20 rounds 20 rounds	interrupted bursts ¹ one continuous burst ²

✓c. Instruction 2 under table IV, 2nd line: Delete the words, "of each barrel".

✓d. Page 35, para. 4.5.4.1.2: Delete the second sentence beginning on line 4 of paragraph.

FOR THE COMMANDER:

James W. Gray
Maj Ord C
(for) F. I. ABEL
Chief
National Maintenance Point



DEPARTMENT OF THE ARMY
HEADQUARTERS, UNITED STATES ARMY WEAPONS COMMAND
ROCK ISLAND ARSENAL
ROCK ISLAND, ILLINOIS 61202

Hoffman/cd/5470

IN REPLY REFER TO:
AMSWE - SMM-SA

16 November 1965

SUBJECT: Change to USAWECOM DMWI 1005-224 Overhaul of
Machine Gun, 7.62MM M60 and M60 C Chg. 2

TO: SEE DISTRIBUTION

1. Delete all reference to Headspace, Gage, Max.
2. 6415
 - a. Delete page 4 of O.I.P. - 7269028
 - b. Delete page 4 of O.I.P. - 7792084
 - c. Delete from Inspection Equipment List F 7792090
line 7, Headspace, Max. (Barrel Sub Assy. O.I.P. - 7792084),
Headspace, D 7799754.
 - d. Delete from Inspection Equipment List J 7269100,
line 8, Headspace, Max. (Barrel Assy. w/pivot O.I.P.
7269028), Headspace, D 7799754.

FOR THE COMMANDER:

F. I. Abel
F. I. ABEL
Chief

National Maintenance Point

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ROCK ISLAND ARSENAL
ROCK ISLAND, ILLINOIS 61202

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IN REPLY REFER TO:
AMSW - SMM-SA

5 November 1965

SUBJECT: Change to Depot Maintenance Work Instructions
for Overhaul of the Machine Guns 7.62MM M60
and M60C DMWI 1005-224, C1

TO: See Distribution

1. This change affects part II, OIP 7791597.
2. All reference to the drainage hole modification in the rod assembly will be deleted.
3. Operating rods of latest design will not have the drain hole, however, drain holes in the previously designed rods will not be cause for rejection.

FOR THE COMMANDER:

F. I. Abel

F. I. ABEL
Chief
National Maintenance Point

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USAWECOMDMWI 1005-224
U. S. Army Weapons Command
Depot Maintenance Work Instructions for
Overhaul of the Machine Guns, 7.62MM: M60 and M60C

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 PART III	
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 PART IV	
Overhaul Inspection Procedures Applicable to the M60C Machine Gun Only (To be used in addition to PART II)	"
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PART I

NOTE. This document supersedes all previous publications on this subject.

USAWECOMDMWI 1005-224
May 1965

U. S. ARMY WEAPONS COMMAND
DEPOT MAINTENANCE WORK INSTRUCTIONS
FOR
OVERHAUL OF MACHINE GUNS, 7.62-MM:
M60 AND M60C

1. SCOPE

1.1 This specification presents requirements and information for the overhauling of the M60 and M60C 7.62-millimeter (mm.) machineguns and provides specific minimum overhaul standards.

2. APPLICABLE DOCUMENTS

2.1 The following documents, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein:

SPECIFICATIONS

Federal

QQ-C-320

TT-L-50

VV-L-800

- Chromium Plating (Electrodeposited).
- Lacquer (Enamel), Nitrocellulose and Acrylic, Aerosol Halogenated Hydrocarbon, (in Pressurized Dispensers).
- Lubricating Oil, General Purpose, Preservative, (Water-Displacing, Low Temperature).

Military

MIL-P-116

MIL-C-13924

- Preservation, Methods of.
- Coating, Oxide, Black, for Ferrous Metals.

FSC 1005

- | | |
|-------------|---|
| MIL-P-16232 | - Phosphate Coatings, Heavy, Manganese or Zinc Base (for Ferrous Metals). |
| MIL-I-45607 | - Inspection Equipment, Supply and Maintenance of. |
| MIL-C-45662 | - Calibration System Requirements. |

STANDARDS

Military

- | | |
|-------------|--|
| MIL-STD-105 | - Sampling Procedures and Tables for Inspection by Attributes. |
| MIL-STD-109 | - Quality Assurance Terms and Definitions. |
| MS20995 | - Wire, Lock. |
| MS33540 | - Safety Wiring, General Practice For. |

DRAWINGS

U. S. Army Weapons Command

- | | |
|-------------|--|
| C7269214 | - Diagram, Targeting and Accuracy (M60 Machinegun). |
| C7269414 | - Diagram, Targeting and Accuracy (M60C Machinegun). |
| C7792281 | - Touch-up Procedure, General Data. |
| IEL 7269100 | - List of Inspection Equipment (M60 Machinegun). |
| IEL 7792090 | - List of Inspection Equipment (M60C Machinegun). |

(Inspection equipment drawings referenced in this specification form a part of Drawings IEL 7269100 or IEL 7792090, as applicable.)

PUBLICATIONS

U. S. Army Weapons Command

- | | |
|---|---|
| Index of Overhaul Inspection Procedures, Applicable to Both M60 and M60C Machineguns. | |
| Index of Overhaul Inspection Procedures, Applicable to M60 Machinegun Only. | |
| Index of Overhaul Inspection Procedures, Applicable to M60C Machinegun Only. | |
| P7792090 | - Packaging Data Sheet for Machine Gun, 7.62MM: M60C. |
| P8413999 | - Packaging Data Sheet for Machine Gun, 7.62MM, M60, w/Equipment. |

(Copies of specifications, standards, drawings, and publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

3. REQUIREMENTS

3.1 Material. When replacement parts are required, they will be supplied in accordance with instructions contained in the contract or purchase order (see 6.1). All fastener type components (rivets, pins, etc.) damaged during disassembly shall be replaced. Spring pins, buffer pad assemblies, pivot leg screws, and O-ring packings will not be reused. Ejectors, ejector springs, ejector retainers, and extractor springs will be replaced 100 percent. M60 machinegun manufacturer installed equipment (basic issue items) listed on Packaging Data Sheet P8413999 will be furnished by the Government (see 6.1). Unless otherwise specified, all other materials necessary to perform overhaul shall be furnished by the supplier. The supplier shall provide reclamation procedures to insure the recovery of usable material (see 4.2). Suggested methods of reclamation are contained in section 6. Additional reclamation methods may be utilized by the supplier subject to the approval of the responsible technical agency through the procuring agency.

3.2 Initial production samples. Samples of overhauled machineguns representing initial production shall be forwarded free on board (f.o.b.) destination to the testing agency designated by the procuring activity (see 6.1). Samples shall be representative of materiel which has been inspected and determined to be acceptable. The production samples of machineguns shall be contained in the pilot pack (see 5.1). Upon completion of testing agency inspection, samples may be commercially packaged and returned to the supplier for repackaging in accordance with procurement documents at the supplier's expense.

3.3 Component parts and assemblies. Parts and assemblies of overhauled machineguns shall conform to the configurations, dimensions, tolerance limits, physical properties, degree of surface roughness, fits, protective finishes, and other requirements specified herein and in the applicable Overhaul Inspection Procedures (OIP's) listed on the applicable Index of Overhaul Inspection Procedures.

3.3.1 Protective finishes.

3.3.1.1 Phosphate and black oxide coatings. When phosphate coating or black oxide coating is performed, the following conditions shall apply:

- (a) Phosphate coatings shall be in accordance with type M or type Z, class 1 of MIL-P-16232.
- (b) Black oxide coatings shall be in accordance with class 2 or class 3 of MIL-C-13924 (spot test is not required).
- (c) Phosphate coated parts shall be rinsed in a chromic acid solution. Black oxide parts shall be rinsed in either a chromic acid solution or water as prescribed in the applicable black oxide coating specification.

Upon emergence from the prescribed rinse, parts shall be thoroughly dried before applying the supplementary oil. Drying shall be accomplished by the use of drying ovens, heated forced air circulation, or filtered compressed air. The drying temperature shall not exceed 200° Fahrenheit (F.).

- (d) The supplementary oil shall be a water-displacing preservative oil conforming to VV-L-800.
- (e) No carry over of residues from the phosphating or oxidizing solutions to the supplementary oil shall be permitted. Periodic tests of the oil shall be made at least semimonthly to insure that the oil continues to meet specification requirements for corrosion protection.
- (f) The "Springfield immersion test" (see MIL-P-16232) is authorized for use for accelerated corrosion testing of phosphate coated parts.
- (g) Unless otherwise specified, when abrasive blasting is necessary to prepare surfaces for phosphate or black oxide finishes, any form of abrasive blasting other than grit blasting may be used.
- (h) Phosphate coating of assemblies and groups. Prior to phosphatizing, parts to be phosphate coated as assemblies or groups shall be saturated with water-displacing preservative oil conforming to VV-L-800 and then cleaned using process C-7 of MIL-P-116 except that rubber coated parts shall be cleaned using process C-3. Phosphate coating shall be performed in accordance with instructions specified herein as soon as possible after cleaning.
 - (1) M60 and M60C machineguns. The receiver, operating rod, feed cam channel, cartridge tray frame, and cam actuator assemblies of both the M60 and M60C machineguns shall be phosphate coated as assemblies. No abrasive blasting shall be performed on the operating rod or cam actuator assemblies. The barrel assembly of the M60 machinegun shall be phosphate coated with the bipod pivot assembly and flash suppressor attached, and the barrel assembly of the M60C machinegun shall be phosphate coated with the flash suppressor attached. Prior to phosphate coating, these groups shall be sand blasted. The breech end of the barrel and both ends of the gas cylinder shall be covered or plugged to protect the threaded areas from

sand during blasting. Following sand blasting, all parts including the barrel bore shall be cleaned as necessary. All barrel assembly openings shall be covered or plugged to prevent the solution from entering the bore during phosphatizing.

- (2) M60 machinegun only. The carrying handle, butt stock, rear sight base, rear sight leaf, trigger housing, and trigger assemblies of the M60C machineguns shall be phosphate coated as assemblies. No abrasive blasting shall be performed on the butt stock, rear sight base, and rear sight leaf assemblies. Both the left and right foot housing assemblies shall be phosphate coated with the foot retainer button and spring attached. The forearm assembly shall be phosphate coated with the catch spring removed.

3.3.1.2 Spray lacquer and solid film lubricant. When refinishing of the cover housing assembly, feed pawl assembly, or buffer plunger guide of the M60 and M60C machineguns is required, refinishing shall be accomplished by spraying with a lacquer or solid film lubricant, as specified, in lieu of rephosphatizing. When spraying is performed, the following conditions shall apply:

- (a) Lacquer shall be in accordance with type II, flat black (37038) of TT-L-50.
- (b) Solid film lubricant shall be a product that has been approved by the technical agency (see 6.9.6.3.8).
- (c) Surfaces to be sprayed shall be free of oil, grease, dirt, scale, rust, and other foreign matter.
- (d) The cover housing assembly with the cheek pad assembly attached shall be sprayed with lacquer. During the spraying operation, the cheek pad assembly shall be shielded from the spray.
- (e) The feed pawl assembly shall be sprayed with solid film lubricant.
- (f) The buffer plunger guide shall be sprayed with solid film lubricant without being disassembled from the buffer housing assembly. During the spraying operation, the buffer tube shall be shielded from the spray.

3.3.1.3 Chromium plating. When chromium plating is performed, plating shall be in accordance with class 2 of QQ-C-320.

3.3.1.4 Touchup material. Bright surfaces on metal components which are exposed during assembly operations on areas such as surfaces of rivets, pins, screw heads, staking marks and the like, may be refinished using materials and procedures in accordance with Drawing C7792281 in lieu of refinishing with the specified final protective finish.

3.3.2 M60 and M60C machineguns.

3.3.2.1 Barrel lock lever. The barrel lock lever shall move manually between the open and closed positions and shall be retained in either position by spring action until manually changed, and shall retain the barrel assembly in the receiver assembly when set in the closed position.

3.3.2.2 Bolt assembly. With the cover assembly opened and the bolt assembly disengaged from the operating rod yoke, the bolt assembly shall move of its own weight in either direction through its full range of travel in the slideways of the receiver. Firing pin protrusion shall be from 0.035 inch to 0.043 inch.

3.3.2.2.1 Cam actuator assembly. The cam actuator assembly shall be retained on the bolt by the bolt plug and shall rotate without binding on the bolt. The bolt guide roller and the cam actuator roller shall be retained on the cam actuator by the roller rivet and shall rotate without binding on the cam actuator.

3.3.2.2.2 Ejector. The ejector shall be retained in the bolt by the staked ejector retainer and shall be held in the forward position by spring action. The ejector shall move through its full range of travel under spring action without binding.

3.3.2.2.3 Extractor. The extractor shall be retained in the bolt by the extractor plunger and spring. The extractor shall move through its full range of travel under spring action without binding.

3.3.2.2.4 Firing pin. The firing pin shall move through its full range of travel in the bolt under spring action without binding.

3.3.2.3 Buffer assembly. ~~The buffer assembly shall be retained in the receiver assembly by the buffer retaining yoke. The buffer retaining yoke and the buffer assembly shall disassemble from the receiver assembly without the use of tools. The plunger shall move through its full range of travel in the housing assembly and shall return to its original position by spring action after partial or full travel. Following preliminary inspection and cleaning of the buffer assembly, a light coat of lubricant approved by the technical agency (see 6.9.6.3.9) shall be applied to the plunger shaft and packing. Care shall be exercised to insure that the interior of the tube remains free of lubricant. The buffer assembly shall be marked in accordance with figure 3A.~~

3.3.2.4 Cartridge feed tray assembly. The cartridge feed tray assembly shall be retained on the receiver by the cover hinge pin.

3.3.2.4.1 Cartridge retainer pawl. The cartridge retainer pawl shall be retained in the frame assembly by the shaft. The pawl shall move through its full range of travel under spring action without binding and shall be returned to and retained in its original position by action of the spring after partial or full travel.

3.3.2.4.2 Cartridge rollers. The cartridge rollers shall be retained in the frame assembly by the shaft and shall rotate without binding on the shaft.

3.3.2.5 Cocking handle assembly and cocking handle guide. The cocking handle assembly shall be retained on the receiver by the cocking handle guide and shall move without binding through its full range of travel in the slideways of the receiver. The cocking handle assembly shall be held in the forward stop position by the spring action of the retaining latch. When retracted, the cocking handle assembly shall engage the operating rod assembly and shall retract the operating rod assembly and the bolt assembly. The cocking handle guide shall be fastened securely to the receiver by the screw and lock washer so that there shall be no relative movement.

3.3.2.6 Cover assembly. The cover assembly shall be retained on the receiver assembly by the cover hinge pin. The cover assembly shall be capable of being locked in the closed position by the cover latch only when the bolt assembly is fully retracted. The cover shall open when the cover latch is released, and when fully opened, it shall be retained in the fully open position by spring action. All riveted and brazed parts shall be tight, undamaged, and without relative movement.

3.3.2.6.1 Latch lever assembly. The latch lever assembly shall rotate manually to disengage the cover assembly from the receiver assembly and shall be returned to the stop position by spring action after partial or full travel. The latch lever assembly shall rotate the cover latch to lock and unlock the cover assembly.

3.3.2.6.2 Cartridge guides. The cartridge guides shall be retained in the cover housing assembly by the cartridge guide shaft and retaining ring or cotter pin. The cartridge guides shall operate through their full range of travel under spring action without binding.

3.3.2.6.3 Feed cam assembly. The feed cam assembly shall be retained in the cover housing assembly by the feed cam retainer and shall move through its full range of travel under spring action without binding. The feed cam assembly shall return to its stop position by

spring action after partial or full travel. Movement of the feed cam assembly shall operate the feed pawl assembly.

3.3.2.6.4 Feed pawl assembly. The feed pawl assembly shall be retained in the cover housing assembly by the chassis rollers and when disengaged from the feed lever assembly shall move of its own weight through its full range of travel.

3.3.3 M60 machinegun only.

3.3.3.1 Barrel assembly with bipod assembly. The barrel assembly with bipod assembly shall be capable of being manually assembled to and disassembled from the receiver when the barrel lock lever is in the vertical position and when the bolt is fully retracted.

3.3.3.1.1 Barrel assembly. The barrel assembly shall be free of cracks, seams, pits, burs, corrosion, bulges, and deformations, and the chromium plating shall be free of flaking, stripping, and evidence of erosion, porosity, and chipped plating except as permitted by the applicable OIP (see 6.2).

3.3.3.1.1.1 Gas cylinder. The gas cylinder shall be fastened securely on the tube assembly by the gas cylinder rivets so that there shall be no relative movement (see 6.2). With the barrel assembly with bipod assembly disassembled from the receiver assembly, the gas piston shall move of its own weight in either direction through its full range of travel in the gas cylinder.

3.3.3.1.1.2 Front sight. The front sight shall be fastened securely on the tube assembly by the front sight rivets so that there shall be no relative movement.

3.3.3.1.2 Bipod assembly. The bipod assembly shall be retained on the barrel assembly by the flash suppressor and when assembled shall be capable, by its own weight, of rotating on the tube assembly between its stop positions. The legs shall lock in place in the open or folded position and shall be capable of being manually released from each position. The inner legs shall be capable of being manually extended and shall lock under spring action of the retainer in any of the five locking positions. The inner legs shall not retract from any locked position unless the retainers are manually depressed.

3.3.3.1.3 Flash suppressor. The flash suppressor shall be fastened securely to the barrel assembly by the staked pin so that there shall be no relative movement.

3.3.3.1.4 Gas cylinder extension, nut, and plug. The gas cylinder extension and nut shall be assembled securely to the gas cylinder so that there shall be no relative movement and shall be retained by the lock washers. The gas cylinder plug shall be assembled to the gas cylinder so that there shall be no relative movement when the plug is drawn up with a torque of 5 to 15 pound-feet.

3.3.3.2 Rear sight assembly. The rear sight base shall be staked securely to the dovetail recess of the receiver, after targeting and accuracy firing tests, so that there shall be no relative movement of the rear sight base. The rear sight leaf shall move manually between the horizontal and vertical positions and shall be held in the vertical position under spring action until manually changed. When the elevation button is depressed the aperture slide shall move without binding in the leaf, and when the elevation button is released the aperture slide shall be held in position under spring action. The elevation and windage adjustment knobs shall turn manually through their full range of travel and shall produce position retention perceptible by touch for each detent notch when the sight is adjusted.

3.3.3.3 Butt stock assembly. The butt stock assembly shall be retained on the receiver by the buffer assembly under spring action of the latch. The butt stock assembly shall move longitudinally on the receiver through its full range of travel and shall return to its original position by spring action after partial or full travel. The butt stock assembly shall disassemble from the receiver when the latch is depressed using a tool simulating the bullet nose of a cartridge and shall manually reassemble to the receiver without the use of tools.

3.3.3.3.1 Shoulder rest assembly. The shoulder rest assembly shall move manually between the open and closed positions and shall be retained in either position by spring action.

3.3.3.3.2 Sling swivel assembly. The sling swivel assembly shall be fastened to the butt stock assembly by the nut so that there shall be no relative movement except that the swivel loop shall rotate without binding.

3.3.3.4 Carrying handle assembly. The carrying handle assembly shall be retained on the receiver by the staked handle pin. The carrying handle assembly shall be held in the side position or in the carrying position by spring action and shall move manually from one position to the other.

3.3.3.5 Forearm assembly. The forearm assembly shall be retained on the receiver by the spring catch. The forearm assembly shall disassemble from the receiver when the spring catch is depressed using a tool simulating the bullet nose of a cartridge when the barrel assembly with bipod assembly is removed from the machinegun. The sling swivel shall be fastened to the forearm assembly by the nut so that there shall be no relative movement except that the swivel loop shall rotate without binding.

3.3.3.6 Operating rod assembly.

3.3.3.6.1 With the cover assembly opened, the drive spring and guide assembly disassembled from the operating rod assembly, and the sear disengaged; the operating rod assembly, together with the bolt assembly, shall slide from the open to closed position by its own weight.

3.3.3.6.2 The operating rod assembly shall manually assemble to and disassemble from the slideways of the receiver. The yoke and head shall be retained on the tube by staked rivets so that there shall be no relative movement of these parts. The roller shall be retained on the yoke by the yoke roller pin and shall rotate without binding. With the trigger released and the operating rod retracted into the cocked position, the sear engagement notch on the operating rod shall be engaged by the sear and the operating rod shall be held in the cocked position until the trigger is pulled.

3.3.3.7 Receiver assembly group. The slideways of the receiver shall be smooth and free of burs. The rear mounting pin shall be retained on the receiver by the staked pins. All riveted parts shall be tight, undamaged, and without relative movement. The magazine support spring shall be riveted securely to the magazine bracket. The latch pins shall be retained by the cotter pins. The magazine latch and the magazine release latch shall move through their full range of travel and shall return to the normal position without binding. The magazine shall assemble to the magazine bracket without manual operation of the latches and shall be retained in the bracket by the latches. When the release latch is manually operated, it shall be possible to manually remove the magazine from the bracket.

3.3.3.8 Trigger mechanism grip assembly. The trigger mechanism grip assembly shall be retained on the receiver assembly by the retaining pin and shall disassemble from the receiver assembly without the use of tools. The retaining pin shall be locked in place by the spring lock. Use of a tool will be permitted, when required, to assist in disassembly of the spring lock.

3.3.3.8.1 Safety. The safety shall move manually between the safe and fire positions, and shall remain in the position set under spring action until reset manually. The trigger mechanism shall operate when the safety is positioned at the letter "F" and shall not operate when the safety is positioned at the letter "S."

3.3.3.8.2 Sear. The sear shall be capable of full engagement with the sear engagement notch on the operating rod and of holding the operating rod in a cocked position. When the safety is in the firing position and the trigger is pulled, the sear shall disengage from the

sear engagement notch on the operating rod allowing the operating rod to move forward under spring action. When the trigger is released, the sear shall return to the engaging position by spring action of the sear plunger.

3.3.3.8.3 Trigger. The trigger shall return to its normal forward position under spring action after partial or complete trigger pull.

3.3.4 M60C machinegun only.

3.3.4.1 Barrel assembly. The barrel assembly shall be capable of being manually assembled to and disassembled from the receiver when the barrel lock lever is in the vertical position and when the bolt is fully retracted. The barrel assembly shall be free of cracks, seams, pits, burs, corrosion, bulges, and deformations, and the chrome plating shall be free of flaking, stripping, and evidence of erosion, porosity, and chipped plating except as permitted by the applicable OIP (see 6.2).

3.3.4.1.1 Gas cylinder. The gas cylinder shall be fastened securely on the tube assembly by the gas cylinder rivets so that there shall be no relative movement (see 6.2). With the barrel assembly disassembled from the receiver assembly, the gas piston shall move of its own weight in either direction through its full range of travel in the gas cylinder.

3.3.4.1.2 Flash suppressor. The flash suppressor shall be fastened securely to the barrel assembly by the staked pin so that there shall be no relative movement.

3.3.4.1.3 Gas cylinder extension, nut, and plug. The gas cylinder extension and nut shall be assembled securely to the gas cylinder so that there shall be no relative movement and shall be retained by the lock washers. The gas cylinder plug shall be assembled to the gas cylinder so that there shall be no relative movement when the plug is drawn up with a torque of 5 to 15 pound-feet. The gas cylinder plug and gas cylinder extension lockwasher shall be lockwired to the gas cylinder with wire conforming to MS20995-C32. The lockwire shall be installed in accordance with MS33540 (double twist method).

3.3.4.2 Backplate assembly. The backplate assembly shall be retained on the receiver by engagement of the buffer assembly with the backplate catch and shall disassemble from the receiver assembly and buffer assembly without the use of tools. All riveted or welded parts shall be tight and undamaged so that there shall be no relative movement.

3.3.4.3 Operating rod assembly.

3.3.4.3.1 With the cover assembly opened, the drive spring and guide assembly disassembled from the operating rod assembly, and the sear disengaged; the operating rod assembly, together with the bolt assembly, shall slide from the open to closed position by its own weight.

3.3.4.3.2 The operating rod assembly shall manually assemble to and disassemble from the slideways of the receiver. The yoke and head shall be retained on the tube by staked rivets so that there shall be no relative movement of these parts. The roller shall be retained on the yoke by the yoke roller pin and shall rotate without binding. With the solenoid deenergized and the operating rod retracted into the cocked position, the sear engagement notch on the operating rod shall be engaged by the sear and the operating rod shall be held in the cocked position until the solenoid is energized.

3.3.4.4 Receiver assembly group. The slideways of the receiver assembly shall be smooth and free of burs. The rear mounting pin shall be retained on the receiver by the staked pins. All riveted parts shall be tight, undamaged, and without relative movement. The magazine support spring shall be riveted securely to the magazine bracket. The latch pins shall be retained by the cotter pins. The magazine latch and the magazine release latch shall move through their full range of travel and shall return to the normal position without binding. The ammunition chute adapter shall assemble to the magazine bracket and shall be retained in the bracket by the latches, and when the release latch is manually operated, it shall be possible to manually remove the adapter from the bracket. The feed mechanism shield shall be retained between the receiver and magazine bracket under spring action of the shield. When set in position, the shield shall not interfere with the seating of the cartridge feed tray assembly and it shall remain in position until manually removed.

3.3.4.5 Trigger actuator. The trigger actuator shall be retained on the receiver assembly by the retaining pin and shall disassemble from the receiver assembly without the use of tools. The retaining pin shall be locked in place by the retaining pin spring lock.

3.3.4.5.1 Solenoid. The solenoid shall be securely retained on the solenoid housing by the rim clenching clamp which shall be held in position by the clamp bolt. There shall be no relative movement of these parts when the clamp bolt is drawn up with a torque of 8 to 10 pound-feet. The clamp bolt shall be lockwired to the clamp with wire conforming to MS20995-C32. The lockwire shall be installed in accordance with MS33540 (double twist method). The solenoid plunger and push rod (or armature and shaft) shall move throughout the full range of travel without binding and shall return to their original positions under spring action.

3.3.4.5.2 Sear. The sear shall be capable of full engagement with the sear engagement notch on the operating rod and of holding the operating rod in a cocked position. When the solenoid is energized, the sear shall disengage from the sear engagement notch on the operating rod allowing the operating rod to move forward under spring action. When the solenoid is deenergized, the sear shall return to the engaging position by spring action of the sear plunger.

3.4 Headspace. The headspace of overhauled machineguns shall be from 1.6315 inch to 1.6380 inch when tested as specified in 4.4.2.2.1.14 or 4.4.2.2.2.12, as applicable, and 4.5.1.

3.5 Trigger pull (M60 machinegun only). The trigger pull shall be free of creep and shall be greater than 6 pounds but no greater than 11 1/2 pounds when tested as specified in 4.4.2.2.1.15 and 4.5.2. Creep shall be interpreted to mean any perceptible rough movement (see 6.2) between the time the trigger slack is taken up and the sear is disengaged from the operating rod.

3.6 Pressure resistance. Overhauled machineguns shall be capable of withstanding the pressure resistance test (firing of one Government standard 7.62-mm. ball cartridge) when tested as specified in 4.4.3.2 and 4.5.3. Parts shall be free of cracks and other injurious defects after pressure resistance firing.

3.7 Functioning.

3.7.1 M60 machineguns. Overhauled M60 machineguns shall operate without malfunctions or unserviceable parts and the cyclic rate of fire shall be within 500 to 650 rounds per minute when tested as specified in 4.4.3.2 and 4.5.4.1.

3.7.2 M60C machineguns. Overhauled M60C machineguns shall operate without malfunctions or unserviceable parts and the cyclic rate of fire shall be within 500 to 750 rounds per minute when tested as specified in 4.4.3.2 and 4.5.4.2.

~~3.8 Targeting and accuracy~~

~~3.8.1 M60 machineguns. Nine rounds of a 10 round burst fired from the overhauled M60 machinegun at a range specified in table I shall be within or cut the edge of a circle of the size specified for that range to qualify for accuracy, and the 9 shots shall be within or cut the edge of the specified targeting area to qualify for targeting when tested as specified in 4.4.3.2 and 4.5.5.1. After testing and adjustment of sights, the rear sight elevation scale shall have additional adjustment of not less than 0.031 inch remaining in both directions (0.031 inch is equal to six clicks of movement of the aperture).~~

~~Table I. M60 targeting and accuracy requirements~~

Range¹	Accuracy (diameter of circle)	Targeting area²	
		Height	Width
	<u>Inches</u>	<u>Inches</u>	<u>Inches</u>
1,000 inches	3.0	8.0	6.0
50 yards	5.4	14.4	10.8
100 yards	10.8	28.8	21.6

~~¹Optional, unless otherwise specified.~~

~~²The location of the targeting area (heavy outline) on the target shall be as specified on the targeting and accuracy diagram, Drawing C7269214.~~

~~3.8.2 M60C machineguns. Nine rounds of a 10-round burst fired from the overhauled M60C machinegun at a range specified in table II shall be within or cut the edge of a circle of the size specified for that range to qualify for accuracy, and the 9 shots shall be within or cut the edge of the specified targeting area to qualify for targeting when tested as specified in 4.4.3.2 and 4.5.5.2.~~

~~Table II. M60C targeting and accuracy requirements~~

Range¹	Accuracy (diameter of circle)	Targeting area² (side of square)
		<u>Inches</u>
<u>Yards</u>	<u>Inches</u>	
50	8	18.5
100	16	37.0

~~¹Optional, unless otherwise specified.~~

~~²The location of the targeting area (grid) on the target shall be as specified on the targeting and accuracy diagram, Drawing C7269414.~~

3.9 Reliability. Overhauled machineguns shall be capable of passing a 1,000-round reliability test as specified in 4.4.3.3 and 4.5.6 with not more than the number of malfunctions and unserviceable parts allowed in table III, and the average cyclic rate of fire for the entire test shall be within the limits specified in 3.7.1 or 3.7.2, as applicable.

Table III. Malfunctions and unserviceable parts

Code	Malfunctions ¹	Number permitted in the 1,000-round reliability test
LP	Loosening of parts	0
FF	Failure to feed	1
FEJ	Failure to eject	1
FEX	Failure to extract	0
OM	Other malfunctions	1
	Unserviceable parts ¹	Number permitted in the 1,000-round reliability test
UP	Part not specified ²	-

¹When malfunctions are traceable to particular parts, it is permissible to replace such parts and record them as unserviceable, subject to limitations of table III. When it is definitely established by the Government representative that previously recorded malfunctions are attributable to an unserviceable part, such malfunctions shall not be counted against the machinegun being tested, provided that they occurred not more than 200 rounds prior to replacement of the unserviceable part. These 200 rounds shall have been fired with the unserviceable part. However, such malfunctions shall remain recorded and properly identified. An unserviceable part is one that causes malfunctions or impairs the safety of the weapon. Malfunctions attributable to links and ammunition shall not be counted against the machinegun however, such malfunctions shall be recorded.

²One unserviceable part shall be allowed in each 1,000-round test and shall be subject to the judgment of the Government representative that the failure does not represent an unsafe condition or a defective condition which is prevalent throughout the lot of items involved.

3.10 Marking. Overhauled machineguns shall be marked in accordance with figure 47. Receivers shall be marked by stamping with 1/16-inch high letters.

3.11 Serviceability. Overhauled machineguns shall equal new weapons in functioning and shall approximate new weapons in appearance. Metal parts shall be free of corrosion. Repaired surfaces shall approximate the degree of surface roughness of the original finish. Blind holes and pockets shall be free of sand, sludge, grit, or other foreign matter. Rubber coatings shall be black and free of streaks, abrasions, bald spots, blisters, cracks, cuts, splits, tears, and evidence of incomplete adhesion to the metal surface.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own facilities or any other commercial laboratory acceptable to the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Quality assurance terms and definitions. Quality assurance terms and definitions used herein are in accordance with MIL-STD-109.

4.1.2 The following provisions form a part of each OIP listed on the Indexes of Overhaul Inspection Procedures:

- (a) Numbers appearing in "Inspection method" column of classification of defects refer to gages applicable to referenced characteristic. When "Measure" is specified as the method of inspection, standard measuring or supplier's gages which have been certified by or for the Government shall be used.
- (b) When "Visual" is specified as the method of dimensional inspection, the sample shall be either scaled or compared with a specimen of known acceptable quality (see 6.2).
- (c) When "Manual" is specified as the method of inspection, the sample shall be physically tested for secureness, rigidity, operation, or smoothness of action, as applicable.
- (d) When "Visual" is specified as the method of inspection of parts for protective coating:
 - (1) The finish must be complete, uniform in color, and free of pits, corrosion, scratches, and worn areas incurred during handling or assembly operations. Sparkle or glitter on phosphate coatings in sun-light indicates a questionable large crystalline structure. Final determination of acceptability of such questionable parts shall be by the accelerated corrosion test.
 - (2) Bright surfaces resulting from assembly operations which have been covered with a touchup paint shall be approximately the color of the surrounding surface.
 - (3) Parts which have been joined by brazing may have brazing material visible at the joints.

- (e) When serviceability is listed as a defect, the presence of any of the following shall be cause for rejection of the part:
- (1) Sand, sludge, grit, or other foreign matter.
 - (2) Cracks, burs, mutilations, deformations, or unauthorized alterations on metal parts.
 - (3) Streaks, abrasions, bald spots, blisters, cracks, cuts, splits, and tears on rubber coatings, and evidence of incomplete adhesion to the metal surface.

4.2 Preliminary inspection and repair.

4.2.1 Disassembly. The supplier shall clean each machinegun as required and disassemble each machinegun to the extent necessary to conduct preliminary inspection and perform necessary repairs. No further disassembly than that required by the applicable OIP need be made.

4.2.2 Inspection. Inspection of parts and assemblies of each machinegun shall be conducted by the supplier in accordance with the applicable OIP. When a noncorrectable defect is encountered, no further inspection need be performed on the defective part. In the case of assemblies, the defective part shall be removed and inspection shall continue on the remaining part or parts.

4.2.3 Defective parts.

4.2.3.1 Nonreparable.

4.2.3.1.1 Parts found to be defective and not reparable, shall be coded (by defect number or numbers, see applicable OIP) and shall be stored in readily identifiable containers in a bonded storage area. The Government representative shall accomplish verification of supplier's inspection findings prior to disposition of defective material. Non-reparable parts shall be disposed of in accordance with instructions contained in the contract or purchase order (see 6.1). The supplier shall maintain at all times a complete and accurate record of defective parts.

4.2.3.1.2 Government verification shall be accomplished on a sampling basis. The sample size shall be in accordance with MIL-STD-105, using inspection level II, and the acceptable quality levels (AQL's) shall be in accordance with the applicable OIP. Finding of usable or reclaimable parts in excess of allowable acceptance number shall be cause for screening of the represented parts by the supplier.

4.2.3.2 Reparable. Parts found to be acceptable except for missing or defective phosphate or black oxide coating shall be refinished as applicable by the supplier (see 3.3.1). Parts having other reparable defects shall be reworked in accordance with the instructions contained in the contract or purchase order (see 6.1).

4.2.4 Reassembly. After repair or replacement (see 3.1) of defective parts, machineguns shall be reassembled by the supplier.

4.3 Initial production sample inspection. Inspection of initial production samples (see 3.2) and pilot pack (see 5.1) shall be performed at the designated testing agency. Initial production samples and pilot pack shall be subjected to the inspection specified herein and such other inspection as is necessary to determine compliance with the requirements of the contract. The level A and B pilot packs shall be subjected to the free fall drop test specified in MIL-P-116 except that the drop height shall be 21 inches.

4.4 Final inspection.

4.4.1 Inspection lot. The formation, size, and presentation of inspection lots of machineguns, parts, and packaging shall be in accordance with MIL-STD-105. Inspection lots shall be as large as practicable, in consideration of quality history, manufacturing conditions, and supplier's delivery schedule, and within the limitations specified herein. Machineguns shall be assembled from lots of component parts that have met all inspection requirements specified herein. Reliability test lot size shall be as specified in 4.4.3.3.

4.4.2 Examination.

4.4.2.1 Component parts. Examination of parts shall be performed on a sampling basis in accordance with MIL-STD-105 and in accordance with the applicable OIP's. This examination shall be performed after preliminary inspection and all rework operations have been completed and prior to assembly into the end item.

4.4.2.2 Machineguns. Final examination of machineguns shall be performed after completion of all firing tests and just prior to preservation and packaging. Each step in the examination shall include a visual examination for proper cleaning and presence of the specified coating. Machineguns failing to meet any of the requirements shall be rejected. Each machinegun shall be examined as specified in 4.4.2.2.1 or 4.4.2.2.2, as applicable.

4.4.2.2.1 M60 machineguns.

4.4.2.2.1.1 Visually examine each overhauled M60 machinegun for cleanliness, serviceability, and completeness of repairs, assembly, finish, and marking. Manually examine (see 6.2) machinegun for functioning of operating parts, and visually examine markings for clarity and legibility. (See 3.3, 3.3.1, 3.3.2, 3.3.3, 3.10, and 3.11.)

4.4.2.2.1.2 Butt stock assembly.

- (a) Manually examine butt stock assembly for compliance with 3.3.3.3.
- (b) Disassemble butt stock assembly from the receiver.

4.4.2.2.1.2.1 Shoulder rest assembly. Manually examine shoulder rest assembly for compliance with 3.3.3.3.1.

4.4.2.2.1.2.2 Sling swivel assembly. Manually examine sling swivel assembly for compliance with 3.3.3.3.2.

4.4.2.2.1.3 Buffer assembly.

- (a) Manually examine for secure retention of buffer assembly in receiver.
- (b) Disassemble buffer assembly from receiver by pushing buffer forward and removing buffer retaining yoke. Manually examine to assure that yoke disassembles from receiver freely.
- (c) Examine spring action of buffer assembly for compliance with 3.3.2.3.
- (d) Visually examine shaft for presence of prescribed lubricant (see 3.3.2.3).
- (e) Visually examine for presence of prescribed markings (see figure 34).
- (f) Visually examine epoxy adhesive around plunger guide for breaks in seal.

4.4.2.2.1.4 Driving spring and driving spring guide assembly.

- (a) Disassemble driving spring and guide assembly from operating rod assembly and buffer plunger.
- (b) Visually examine ends of spring for secure brazing.
- (c) Visually examine guide assembly for secure brazing of stop to rod.

4.4.2.2.1.5 Operating rod assembly and bolt assembly action.
Examine action of operating rod assembly and bolt assembly for compliance with 3.3.3.6.1 by manually changing the axis of the machinegun from the vertical position with the butt stock down to the vertical position with the butt stock up.

4.4.2.2.1.6 Operating rod assembly.

- (a) Disassemble operating rod assembly from bolt assembly and visually and manually examine operating rod assembly for compliance with 3.3.3.6.2.
- (b) Visually examine rod for mutilations on sear engagement notch.
- (c) Visually examine yoke for mutilations or burs on bolt camming surfaces.
- (d) Visually examine roller for mutilations.

4.4.2.2.1.7 Bolt assembly.

- (a) Visually examine to assure that ejector face is flush with or below front of bolt and ejector retaining pin is securely staked.
- (b) Check free movement of bolt assembly (see 3.3.2.2) by manually changing the axis of the machinegun from the vertical position with the butt stock down to the vertical position with the butt stock up and then back to the original position.
- (c) Examine firing pin protrusion using the inspection equipment conforming to Drawing A7274754 (see 3.3.2.2).

4.4.2.2.1.7.1 Cam actuator assembly. Manually examine cam actuator assembly for compliance with 3.3.2.2.1.

4.4.2.2.1.7.2 Ejector. Manually examine retention and spring action of ejector for compliance with 3.3.2.2.2.

4.4.2.2.1.7.3 Extractor. Manually examine spring action of extractor for compliance with 3.3.2.2.3.

4.4.2.2.1.7.4 Firing pin. Manually examine firing pin for compliance with 3.3.2.2.4.

4.4.2.2.1.7.5 Disassembly of bolt assembly.

- (a) Disassemble all parts except ejector from bolt assembly.

- (b) Visually examine all parts for mutilations, breaks, or cracks.
- (c) Visually examine bolt lugs, operating cam cut, rollers, guideways, cam actuator assembly, extractor lips, and ejector face for cracks, burs, sharp edges, or deformations.
- (d) Visually examine firing pin striker point; it shall be smooth and free of pits and burs. Examine fillet radii at spools for cracks and deformations.
- (e) Reassemble bolt assembly, assuring that cam actuator assembly is properly assembled with roller and forward on bolt and that extractor is securely retained by the plunger and spring.

4.4.2.2.1.8 Trigger mechanism grip assembly.

- (a) Disassemble trigger mechanism assembly from receiver assembly manually examining for compliance with 3.3.3.8.
- (b) Visually examine for secure riveting of trigger mechanism frame assembly to channel assembly.

4.4.2.2.1.8.1 Safety. Visually and manually examine safety for compliance with 3.3.3.8.1.

4.4.2.2.1.8.2 Sear. Visually and manually examine sear for compliance with 3.3.3.8.2.

4.4.2.2.1.8.3 Trigger. Manually examine trigger for compliance with 3.3.3.8.3.

4.4.2.2.1.9 Cover assembly. Visually and manually examine cover assembly for compliance with 3.3.2.6.

4.4.2.2.1.9.1 Latch lever assembly. Manually examine spring action of latch lever assembly for compliance with 3.3.2.6.1.

4.4.2.2.1.9.2 Cartridge guides.

- (a) Visually and manually examine retention and spring action of cartridge guides for compliance with 3.3.2.6.2.
- (b) Visually examine cartridge guides for cracks, burs, sharp edges, or deformations.

4.4.2.2.1.9.3 Feed cam assembly.

- (a) Visually and manually examine feed cam assembly for compliance with 3.3.2.6.3.
- (b) Visually examine feed cam assembly for burs, cracks, sharp edges, or deformations.

4.4.2.2.1.9.4 Feed pawl assembly.

- (a) Visually and manually examine retention and free travel of feed pawl assembly for compliance with 3.3.2.6.4.
- (b) Visually examine feed pawl assembly for cracks, burs, sharp edges, or deformations.

4.4.2.2.1.10 Cartridge feed tray assembly.

- (a) Visually examine cartridge feed tray assembly for compliance with 3.3.2.4.
- (b) Visually examine feed plate guideways and cartridge stops for cracks, burs, sharp edges, or deformations.

4.4.2.2.1.10.1 Cartridge retainer pawl.

- (a) Visually and manually examine retention, spring action, and free travel of cartridge retainer pawl for compliance with 3.3.2.4.1.
- (b) Visually examine the cartridge retaining pawl for cracks, burs, sharp edges, or deformations.

4.4.2.2.1.10.2 Cartridge rollers. Manually examine cartridge rollers for compliance with 3.3.2.4.2.

4.4.2.2.1.11 Barrel assembly with bipod assembly - (two per gun). Disassemble barrel assembly with bipod assembly. Assure that with barrel lock lever in the vertical position disassembly from the receiver is readily accomplished. Assemble to and disassemble spare barrel assembly with bipod assembly from the receiver.

4.4.2.2.1.11.1 Barrel assembly. Visually examine barrel assembly for compliance with 3.3.3.1.1.

4.4.2.2.1.11.1.1 Gas cylinder.

- (a) Visually and manually examine gas cylinder for compliance with 3.3.3.1.1.1. Check free movement of gas piston by manually tilting the barrel assembly with bipod assembly from end to end.

- (b) Disassemble gas cylinder nut and extension, lock washers, and piston, and check piston and lock washers for cracks, burs, or deformations. Reassemble, assuring that head of piston is assembled toward breech (rear) end.
- (c) Visually and manually examine gas cylinder plug for secure assembly.

4.4.2.2.1.11.1.2 Front sight. Examine front sight for compliance with 3.3.3.1.1.2.

4.4.2.2.1.11.2 Bipod assembly. Manually examine bipod assembly for compliance with 3.3.3.1.2.

4.4.2.2.1.11.3 Flash suppressor. Examine flash suppressor for compliance with 3.3.3.1.3.

4.4.2.2.1.12 Forearm assembly. Manually examine for compliance with 3.3.3.5.

4.4.2.2.1.13 Receiver assembly group.

- (a) Visually and manually examine receiver assembly group for compliance with 3.3.3.7.
- (b) Visually examine magazine bracket assembly for missing or mutilated cotter pins.
- (c) Manually examine cocking handle guide, screw, and lockwasher for compliance with 3.3.2.5.

4.4.2.2.1.13.1 Cocking handle assembly.

- (a) Manually examine retention and free movement of cocking handle assembly for compliance with 3.3.2.5.
- (b) Manually examine spring action of retaining latch on cocking handle assembly for compliance with 3.3.2.5.

4.4.2.2.1.13.2 Carrying handle assembly. Examine carrying handle assembly for compliance with 3.3.3.4.

4.4.2.2.1.13.3 Barrel lock lever. Examine barrel lock lever positioning under spring action for compliance with 3.3.2.1.

4.4.2.2.1.13.4 Rear sight assembly. Visually and manually examine rear sight assembly for compliance with 3.3.3.2.

4.4.2.2.1.14 Headspace. Prior to reassembly of machinegun, check for headspace requirement (see 3.4) using the test methods specified in 4.5.1.

4.4.2.2.1.15 Reassembled M60 machinegun.

- (a) While reassembling barrel assembly with bipod assembly to receiver assembly, examine to assure that when barrel lock lever is set in closed position barrel is retained in receiver (see 3.3.2.1).
- (b) Reassemble machinegun and hand operate to assure proper function of all parts.
- (c) Check for trigger pull requirement (see 3.5) using the test method specified in 4.5.2.
- (d) Manually examine the safety in the safe and fire positions for the requirements specified in 3.3.3.8.1. When the trigger is pulled, the sear shall not release operating rod when safety is in the "S" position and must release operating rod when safety is in the "F" position.
- (e) Visually examine the machinegun for completeness of assembly.
- (f) Visually examine the machinegun for presence of required markings (see figure 47).

4.4.2.2.2 M60C machineguns.

4.4.2.2.2.1 Visually examine each overhauled M60C machinegun for cleanliness, serviceability, and completeness of repairs, assembly, finish, and marking. Manually examine (see 6.2) machinegun for functioning of operating parts, and visually examine markings for clarity and legibility. (See 3.3, 3.3.1, 3.3.2, 3.3.4, 3.10 and 3.11.)

4.4.2.2.2.2 Trigger actuator.

- (a) Visually and manually examine trigger actuator for compliance with 3.3.4.5.
- (b) Examine electrical function of solenoid and sear action for compliance with 3.3.4.5.2.
- (c) Examine for minimum height of sear catch from top of housing (0.265 inch) with solenoid deenergized.
- (d) Disassemble pin, sear, spring, and plunger from trigger actuator.

4.4.2.2.2.2.1 Solenoid.

- (a) Visually and manually examine solenoid for compliance with 3.3.4.5.1.
- (b) Visually examine end of solenoid plunger (or shaft) for burs and deformations.

4.4.2.2.2.2.2 Sear. Visually examine sear plunger and spring for burs, cracks, and deformations.

4.4.2.2.2.3 Buffer and back plate assemblies.

- (a) Visually and manually examine buffer and back plate assemblies for compliance with 3.3.2.3 and 3.3.4.2 respectively.
- (b) Manually examine for secure retention of buffer assembly in receiver.
- (c) Disassemble buffer assembly from receiver by pushing buffer forward and removing buffer retaining yoke. Manually examine to assure that yoke disassembles from receiver freely.
- (d) Examine spring action of buffer assembly for compliance with 3.3.2.3.
- (e) Visually examine buffer shaft for presence of prescribed lubricant (see 3.3.2.3).
- (f) Visually examine buffer assembly for presence of prescribed markings (see figure 34).
- (g) Visually examine epoxy adhesive around plunger guide for breaks in seal.

4.4.2.2.2.4 Driving spring and driving spring guide assembly.

- (a) Disassemble driving spring and guide assembly from operating rod assembly and buffer plunger.
- (b) Visually examine ends of spring for secure brazing.
- (c) Visually examine guide assembly for secure brazing of stop to rod.

4.4.2.2.2.5 Operating rod assembly and bolt assembly action. Examine action of operating rod assembly and bolt assembly for compliance with 3.3.4.3.1 by manually changing the axis of the machinegun from the vertical position with the back plate down to the vertical position with the back plate up.

4.4.2.2.2.6 Operating rod assembly.

- (a) Disassemble operating rod assembly from bolt assembly and visually and manually examine operating rod assembly for compliance with 3.3.4.3.2.
- (b) Visually examine rod for mutilations on sear engagement notch.
- (c) Visually examine yoke for mutilations or burs on bolt camming surfaces.
- (d) Visually examine roller for mutilations.

4.4.2.2.2.7 Bolt assembly.

- (a) Visually examine to assure that ejector face is flush with or below front of bolt and ejector retaining pin is securely staked.
- (b) Check free movement of bolt assembly (see 3.3.2.2) by manually changing the axis of the machinegun from the vertical position with the back plate down to the vertical position with the back plate up and then back to the original position.
- (c) Examine firing pin protrusion using the inspection equipment conforming to Drawing A7274754 (see 3.3.2.2).

4.4.2.2.2.7.1 Cam actuator assembly. Examine cam actuator assembly for compliance with 3.3.2.2.1.

4.4.2.2.2.7.2 Ejector. Manually examine retention and spring action of ejector for compliance with 3.3.2.2.2.

4.4.2.2.2.7.3 Extractor. Manually examine retention and spring action of extractor for compliance with 3.3.2.2.3.

4.4.2.2.2.7.4 Firing pin. Manually examine firing pin for compliance with 3.3.2.2.4.

4.4.2.2.2.7.5 Disassembly of bolt assembly.

- (a) Disassemble all parts except ejector from bolt assembly.
- (b) Visually examine all parts for mutilations, breaks, or cracks.
- (c) Visually examine bolt lugs, operating cam cut, rollers, guideways, cam actuator assembly, extractor lips, and ejector face for cracks, burs, sharp edges, or deformations.

- (d) Visually examine firing pin striker point; it shall be smooth and free of pits and burs. Examine fillet radii at spools for cracks and deformations.
- (e) Reassemble bolt assembly, assuring that cam actuator assembly is properly assembled with roller end forward on bolt and that extractor is securely retained by the plunger and spring.

4.4.2.2.2.8 Cover assembly. Visually and manually examine cover assembly for compliance with 3.3.2.6.

4.4.2.2.2.8.1 Latch lever assembly. Manually examine spring action of latch lever assembly for compliance with 3.3.2.6.1.

4.4.2.2.2.8.2 Cartridge guides.

- (a) Visually and manually examine retention and spring action of cartridge guides for compliance with 3.3.2.6.2.
- (b) Visually examine cartridge guides for cracks, burs, sharp edges or deformations.

4.4.2.2.2.8.3 Feed cam assembly.

- (a) Visually and manually examine feed cam assembly for compliance with 3.3.2.6.3.
- (b) Visually examine feed cam assembly for burs, cracks, sharp edges or deformations.

4.4.2.2.2.8.4 Feed pawl assembly.

- (a) Visually and manually examine retention and free travel of feed pawl assembly for compliance with 3.3.2.6.4.
- (b) Visually examine feed pawl assembly for cracks, burs, sharp edges or deformations.

4.4.2.2.2.9 Cartridge feed tray assembly.

- (a) Visually examine cartridge feed tray assembly for compliance with 3.3.2.4.
- (b) Visually examine feed plate guideways and cartridge stops for cracks, burs, sharp edges or deformations.

4.4.2.2.2.9.1 Cartridge retainer pawl.

- (a) Visually and manually examine retention, spring action, and free travel of cartridge retainer pawl for compliance with 3.3.2.4.1.
- (b) Visually examine the cartridge retaining pawl for cracks, burs, sharp edges or deformations.

4.4.2.2.2.9.2 Cartridge rollers. Examine cartridge rollers for compliance with 3.3.2.4.2.

4.4.2.2.2.10 Barrel assembly.

- (a) Disassemble barrel assembly. Assure that with barrel lock lever in the vertical position, disassembly from the receiver is readily accomplished (see 3.3.4.1).
- (b) Visually examine barrel assembly for compliance with 3.3.4.1.

4.4.2.2.2.10.1 Gas cylinder.

- (a) Visually and manually examine gas cylinder for compliance with 3.3.4.1.1. Check free movement of gas piston by manually tilting the barrel assembly from end to end.
- (b) Disassemble rear gas cylinder nut and piston. Visually examine piston for cracks, burs, and deformations. Reassemble, assuring that head of piston is assembled toward breech (rear) end.
- (c) Visually and manually examine gas cylinder plug and extension for secure lock wiring and secure assembly (see 3.3.4.1.3).

4.4.2.2.2.10.2 Flash suppressor. Examine flash suppressor for compliance with 3.3.4.1.2.

4.4.2.2.2.11 Receiver assembly group.

- (a) Visually and manually examine receiver assembly group for compliance with 3.3.4.4.
- (b) Visually examine magazine bracket assembly for missing or mutilated cotter pins.
- (c) Manually examine cocking handle guide, screw, and lockwasher for compliance with 3.3.2.5.

4.4.2.2.2.11.1 Cocking handle assembly.

- (a) Manually examine retention and free movement of cocking handle assembly for compliance with 3.3.2.5.
- (b) Manually examine spring action of retaining latch on cocking handle assembly for compliance with 3.3.2.5.

4.4.2.2.2.11.2 Barrel lock lever. Examine barrel lock lever positioning under spring action for compliance with 3.3.2.1.

4.4.2.2.2.12 Headspace. Prior to reassembly of machinegun, check for headspace requirement (see 3.4) using the test methods specified in 4.5.1.

4.4.2.2.2.13 Reassembled machinegun.

- (a) While reassembling barrel assembly to receiver assembly, examine to assure that when barrel lock lever is set in closed position barrel is retained in receiver (see 3.3.2.1).
- (b) Reassemble machinegun and hand operate to assure proper function of all parts.
- (c) Examine electrical function of solenoid and sear action for compliance with 3.3.4.5.2.
- (d) Visually examine machinegun for presence of required markings (see figure 47).
- (e) Visually examine the machinegun for completeness of assembly.

4.4.2.3 Packaging. Examination of packaging of machineguns shall be performed in accordance with the classification of defects and acceptable quality levels (AQL's) specified in 4.4.2.3.1 (see 6.1). Sample size shall be in accordance with MIL-STD-105, using inspection level I. The following provisions shall apply:

- (a) The AQL's are specified as percent defective.
- (b) An individual AQL is specified for each defect, not for a group of defects.
- (c) Examination for packaging defects specified in 4.4.2.3.1 shall apply to each item of the applicable sample of machineguns, interior packages, or exterior containers, as applicable.

4.4.2.3.1 Classification of defects for packaging. (Unless otherwise specified in each listed defect, the packaging requirements are specified on Packaging Data Sheets P8413999 or P7792090, as applicable.)

<u>Categories</u>	<u>Defect</u>	<u>AQL</u>
Critical:	None defined.	
Major:		
101	Illegible or incorrect marking.	1.0
102	Improper level of packaging and packing (see procurement documents).	1.0
103	Missing items of equipment.	1.0
104	Inadequate cleaning and drying.	1.5
105	Improper preservative application and drainage.	1.5
106	Improper assembly of package: position of assemblies in supports, position of separator between supports, and assembly of cells.	1.5
107	Improper closure of interior packages.	1.5
108	Improper closure and strapping of shipping containers.	1.5
Minor:		
201	Workmanship (see 5.4).	4.0

4.4.3 Testing.

4.4.3.1 Inspection prior to firing. Prior to firing tests, the supplier shall perform the following inspection on each machinegun to be fired:

- (a) Visually examine to assure that chamber and bore are clean and free of obstructions.
- (b) Hand operate to assure proper function of all parts. Safety action of M60 machineguns should be positive in both safe and fire positions.

4.4.3.2 Pressure resistance, functioning, and ~~targeting and accuracy firing testing.~~

4.4.3.2.1 M60 machineguns. The supplier shall test each overhauled M60 machinegun for pressure resistance, functioning, and ~~targeting and accuracy~~ using the test methods specified in 4.5.3.1, 4.5.4.1.1, and 4.5.5.1 respectively. Machineguns failing to meet any of the requirements shall be rejected subject to reconditioning in accordance with the contract or purchase order and retest (see 6.1). In addition, the supplier shall test five machineguns from each inspection lot for functioning with the magazine, using the test methods specified in 4.5.4.1.2. Failure of any machinegun in the sample to meet the requirements shall cause rejection of the represented lot subject to reconditioning and retest.

4.4.3.2.2 M60C machineguns. The supplier shall test each overhauled M60C machinegun for pressure resistance, functioning, ~~and targeting and accuracy~~ using the test methods specified in 4.5.3.2, 4.5.4.2, and 4.5.5.2 respectively. Machineguns failing to meet any of the requirements shall be rejected subject to reconditioning in accordance with the contract or purchase order and retest (see 6.1).

4.4.3.3 Reliability testing. One machinegun selected by the Government representative from each 200 overhauled machineguns of the same type shall be tested by the supplier for reliability using the test methods specified in 4.5.6.1 or 4.5.6.2, as applicable. If the reliability requirements are not met, the represented lot shall be rejected subject to retest or reconditioning and further test as a reconditioned lot. A reliability retest of one other machinegun from the same lot shall be made without reconditioning the represented lot, unless, as determined by the Government representative, the failure indicates serious defects in the item, in which case retest shall be made only when authorized by the procuring agency. Failure of the machinegun in the retest to meet the requirements shall cause rejection of the represented lot subject to reconditioning and further testing as a reconditioned lot. Prior to submission of a lot of machineguns as a reconditioned lot, the cause of failure shall be determined and contractor correction shall be effected on all machineguns in the lot. Sample size and test methods for reconditioned lots shall be the same as for retest.

4.4.3.4 Certification. The supplier shall be responsible for testing necessary to accomplish certification. Unless otherwise specified, the supplier shall provide the Government representative with certified statements of compliance with applicable drawings, specifications, and standards for the following materials and processes for each inspection lot of machineguns:

- (a) Phosphate coating - For each day's production from each processing tank, furnish a certified report of the accelerated corrosion test on three samples and a certified statement of compliance with 3.3.1.1 and MIL-P-16232. In lieu of certification, where practicable, the Government representative may witness performance of the accelerated corrosion tests. Failure of any sample shall cause rejection of the represented material.
- (b) Black oxide coating - For each day's production from each processing tank, furnish a certified statement of compliance with 3.3.1.1 and MIL-C-13924 (spot test not required).
- (c) Supplementary oil (see 3.3.1.1 and VV-L-800).

- (d) Chromium plating - For each day's production from each plating tank, furnish a certified statement of compliance with 3.3.1.3 and QQ-C-320.
- (e) Spray lacquer and solid film lubricant (see 3.3.1.2).
- (f) Touchup material (see 3.3.1.4 and Drawing C7792281).

4.4.3.5 Packaging testing. The supplier shall furnish the Government representative with certification that the packaging materials conform to the applicable packaging data sheets and specifications.

4.4.3.5.1 Determination of cleanliness. The supplier shall test items from each inspection lot for cleanliness using the test methods specified in 4.5.7.1. Sampling shall be in accordance with MIL-P-116.

4.4.3.5.2 Heat seal and vacuum retention. The supplier shall test level A unit packages from each inspection lot for heat seal and vacuum retention using the test methods specified in 4.5.7.2 and 4.5.7.3 respectively. Sampling shall be in accordance with MIL-P-116.

4.4.3.5.3 Manufacturer installed equipment. The supplier shall test manufacturer installed equipment packaged in heat sealed bags from each inspection lot for heat seal and quick leak requirements, using the test methods specified in 4.5.7.4. Sampling shall be in accordance with MIL-P-116.

4.4.4 Inspection equipment.

4.4.4.1 Unless otherwise specified in procurement documents (see 6.1), responsibilities for acquisition, maintenance, and disposition of measuring and test equipment prescribed on Lists of Inspection Equipment, Drawings IEL 7269100 or IEL 7792090, as applicable, and for all other inspection equipment required to perform inspection prescribed by applicable specifications, shall be in accordance with MIL-I-45607 and MIL-C-45662.

4.4.4.2 Ammunition and links (see 6.1).

4.4.4.2.1 Ammunition. Unless otherwise specified in procurement documents, ammunition used in firing tests shall be M59 or M80 7.62mm. ball cartridges. A sample of each lot of ball ammunition received should be set aside for use as a standard in cases where failure of machineguns may appear to be caused by faulty ammunition. Dummy-inert cartridges shall be used as required in the functioning firing test.

4.4.4.2.2 Links. Government standard 7.62mm., M13 links shall be used for linking ammunition required for firing tests.

4.5 Test methods.

4.5.1 Headspace test. Both the assigned and spare barrel assembly with bipod assembly of each overhauled M60 machinegun and the barrel assembly of each overhauled M60C machinegun shall be gaged for headspace requirement (see 3.4) while disassembled from the machinegun. The test shall be accomplished in accordance with instructions specified on figure 48.

4.5.2 Trigger pull test (M60 machinegun only). Overhauled M60 machineguns shall be tested for trigger pull requirement (see 3.5) using the inspection equipment in accordance with Drawing D7274758. The machinegun shall be cocked, the safety shall be in the fire position, and the machinegun shall be held in the vertical position with the butt stock down. The load shall be applied gradually to the trigger and exerted in a line parallel to the axis of the barrel bore by a slow steady lift of the machinegun (see figure 46). When the minimum load is applied the operating rod shall not release, and when the maximum load is applied the operating rod shall release. The machinegun shall be recocked by fully retracting the cocking handle assembly and then returning the handle to its forward position each time after a load is applied. The trigger pull shall also be tested for creep by applying pressure manually to the trigger at a uniform rate of increase over a period of not less than 3 seconds.

4.5.3 Pressure resistance test. Machineguns shall be tested for pressure resistance requirement (see 3.6) by firing one Government standard 7.62-mm. ball cartridge (see 4.4.4.2.1) in each machinegun. After firing this round, the machinegun shall be visually examined for cracks, deformations, and other evidence of damage, and the cartridge case shall be visually examined for bulges, splits, rings, and other defects caused by defective barrels. Machineguns passing the pressure resistance test shall be marked as indicated in figure 47.

4.5.3.1 M60 machineguns. Firing shall be accomplished remotely with the machinegun mounted upright in a firing fixture conforming to Drawing F7273925 and with the protective hood positioned over the machinegun.

4.5.3.2 M60C machineguns. Testing shall be accomplished with the machinegun mounted on its right side in a firing fixture conforming to Drawing F11017821 and with the safety shield in position over the machinegun.

4.5.4 Functioning firing test.

4.5.4.1 M60 machineguns.

4.5.4.1.1 Machineguns shall be tested for functioning requirement (see 3.7.1) in accordance with the schedule specified in table IV. The machineguns shall be tested using the firing fixture conforming to Drawing F7273925. The ammunition shall be linked together in 100-round belts with a dummy cartridge separating each 20 rounds (see 4.4.4.2). The belts of ammunition shall hang unsupported vertically from the firing fixture feed tray for a distance of not less than 4 feet (see Drawing C7273911).

Table IV. M60 functioning firing test schedule

	Each machinegun	Type of firing
<i>Spare</i> First barrel	20 rounds	Interrupted bursts ¹
	20 rounds	One continuous burst ²
Second barrel (spare)	20 rounds	Interrupted bursts¹
	20 rounds	One continuous burst²

¹The trigger shall be intentionally released to stop firing at least five times during the interrupted burst firing.

²Rate of fire shall be measured and recorded on every tenth machinegun during the one continuous burst firing of each barrel using a timer gage conforming to Drawing D7273920. Failure of any sample machinegun to meet the cyclic rate of fire requirement shall be cause for measurement of the cyclic rate of fire on the other nine machineguns represented.

4.5.4.1.2 The sample machineguns referenced in 4.4.3.2.1 shall be tested for functioning requirement (see 3.7.1) using the firing fixture specified in 4.5.4.1.1 and using the magazine attached to the machinegun. Firing shall be accomplished using either the assigned or spare barrel assembly with bipod assembly. ~~The magazine shall be loaded with a cartoned 100-round belt of ammunition having a dummy cartridge separating each 20 rounds (see 4.4.4.2).~~ The first 20 rounds shall be fired in interrupted bursts (see note 1 of table IV) and the next 20 rounds shall be fired in one continuous burst.

4.5.4.2 M60C machineguns. Machineguns shall be tested for functioning requirement (see 3.7.2) in accordance with the schedule specified in table V. Testing shall be accomplished with the machinegun mounted on its right side in a firing fixture in accordance with Drawing F11017821. Ammunition shall be fed to the machinegun by cartridge drive from the ammunition box through the flexible chuting as depicted on Drawing F11017821. Ammunition shall be linked together in 500-round belts with a dummy cartridge separating each 20 rounds.

Table V. M60C functioning firing test schedule

Each machinegun	Type of firing
20 rounds 20 rounds	Interrupted bursts ¹ One continuous burst ²

¹Firing shall be intentionally stopped by deenergizing the solenoid and cartridge drive at least five times during the interrupted burst firing. The machinegun shall be checked to assure that the firing stops immediately when the current is discontinued.

²Rate of fire shall be measured and recorded on every tenth machinegun during the one continuous burst firing using a timer gage conforming to Drawing D7273920. Failure of any sample machinegun to meet the cyclic rate of fire requirement shall be cause for measurement of the cyclic rate of fire on the other nine machineguns represented.

~~4.5.5 Targeting and accuracy firing test.~~

4.5.5.1 M60 machineguns.

~~4.5.5.1.1 Each machinegun shall be tested with both its assigned and spare barrel assembly with bipod assembly with the same sight setting for compliance with the targeting and accuracy requirements of 3.8.1. The ammunition and links shall be in accordance with 4.4.4.2.~~

~~4.5.5.1.2 Machineguns shall be tested using the test fixture conforming to Drawing F7273907. With the rear sight set at zero windage and the elevation scale set so that the scale retaining screw is approximately at the midpoint in the slot, the sight aperture slide shall be brought to the elevation setting indicated on the targeting and accuracy diagram. With the sights aligned at 6 o'clock on the sighting image of the targeting and accuracy diagram, a 10-round burst shall be fired for~~

~~the targeting and accuracy requirements. The barrel assembly with bipod assembly shall be replaced by the spare barrel assembly with bipod assembly and with a 6 o'clock hold on the sighting image of a new target a 10-round burst shall be fired for the targeting and accuracy requirements. Adjustment of the sights may be made within the limitations of 4.5.5.1.3 to bring the two barrels within the targeting requirements with the same sight setting. A 10-round warmup burst is allowable when testing each barrel assembly with bipod assembly.~~

4.5.5.1.3 Adjustment to the rear sight shall not cause overhanging of the rear sight base. Vertical adjustment shall be made by movement of the adjustable elevation scale and, after adjustment, determination shall be made that the required additional adjustment is available (see 3.8.1). Filing of the top of the front sight blade shall be allowed to correct for vertical deviation provided that resulting bright areas are covered with an approved touchup material (see 3.3.1.4).

~~4.5.5.1.4 Upon satisfactory completion of the targeting and accuracy firing test, the rear sight base shall be staked in place and the adjustable elevation scale shall be set at the correct scale graduation.~~ *deleted by ch 4, 17 mar. 66. Refer to CH 4 for substituting para.*

4.5.5.2 M60C machineguns. Machineguns shall be boresighted and fired for targeting and accuracy requirements (see 3.8.2) with the machinegun mounted on its right side in a firing fixture conforming to Drawing F11017822.

4.5.5.2.1 The machinegun shall be boresighted in the following manner:

- (a) Fully retract bolt.
- (b) Move barrel lock lever to open position.
- (c) Disassemble barrel assembly from receiver.
- (d) Assemble boresight telescope gage conforming to Drawing C7797808 to boresight expanding mandrel gage conforming to Drawing D7796858.
- (e) Insert mandrel with boresight into barrel socket hole in receiver.
- (f) Move barrel lock lever to closed position.
- (g) Boresight machinegun on sighting image depicted on Drawing C7269414.

4.5.5.2.2 With the mount locked in the boresighted position, the mandrel with boresight removed, and the barrel assembly reassembled to the receiver, a 10-shot burst shall be fired for the targeting and accuracy requirements using the solenoid.

4.5.5.3 Use of nonstandard ammunition. When it is necessary to use ammunition, not standard service ammunition, for targeting and accuracy firing, the lot of suspect ammunition shall be compared to a sample of the service ammunition set aside for use as a standard (see 4.4.4.2.1). If the suspect ammunition is inferior, the targeting and accuracy requirements applicable to the lot of suspect ammunition shall be adjusted. Comparison of ammunition and adjustment of requirements shall be accomplished as follows:

- (a) Fire three 5-shot groups from each of 10 machineguns at the range which the targeting and accuracy test is to be fired using service ammunition and record the average extreme spread of the 30 groups (AES #1).
- (b) Fire three 5-shot groups from the same 10 machineguns at the same range using the suspect ammunition and record the average extreme spread of the 30 groups (AES #2).
- (c) If AES #2 is greater than AES #1, record the difference. (If AES #2 is the same as or less than AES #1, no adjustments in targeting and accuracy requirements are necessary.)
- (d) When adjustment of accuracy requirement is necessary, three-quarters of the difference recorded in (c) above shall be added to the applicable accuracy requirement specified on the targeting diagram.
- (e) When adjustment of targeting requirement is necessary, the difference recorded in (c) above shall be added to both the width and height of the applicable targeting area (heavy outline) specified on the targeting diagram.

4.5.6 Reliability test.

4.5.6.1 M60 machineguns.

4.5.6.1.1 Testing of machineguns for reliability requirements (see 3.9) shall be accomplished with the machineguns held in a firing fixture conforming to Drawing F7273925.

4.5.6.1.2 Firing shall be accomplished using 100-round belts. Every other belt shall be fired in interrupted bursts with at least 10 intentional interruptions in firing. All other belts shall be fired in one continuous burst. One barrel assembly with bipod assembly shall be used throughout the entire test. For the first half of the reliability test, the belts of ammunition shall hang unsupported vertically from the firing fixture feed tray for a distance of not less than 4 feet (see Drawing C7273911); and the second half of the test shall be fired using the magazine, loaded with a cartoned 100-round belt, attached to the machinegun. The ammunition and links shall be in accordance with 4.4.4.2.

4.5.6.1.3 The machinegun shall be cooled to ambient temperature after each 200-round series using cooling aids other than water. The cyclic rate of fire shall be measured and recorded on the last series. At the close of each day's firing, the machinegun shall be protected against corrosion. No parts shall be altered and only parts broken or worn to the extent that they are unserviceable shall be replaced.

4.5.6.1.4 Complete accurate records shall be kept for each reliability test, showing each malfunction and part replacement including the number of the round at which each occurred and corrective action taken.

4.5.6.2 M60C machineguns.

4.5.6.2.1 Testing of machineguns for reliability requirements (see 3.9) shall be accomplished with the machinegun mounted on its right side in a firing fixture conforming to Drawing F11017821. Ammunition shall be fed to the machinegun by cartridge drive from the ammunition box through the flexible chuting as depicted on Drawing F11017821 using 500-round belts.

4.5.6.2.2 The machinegun shall be fired in series of approximately 200 rounds. The first 100 rounds shall be fired in interrupted bursts and the second 100 rounds shall be fired in one continuous burst. Firing shall be intentionally stopped (by deenergizing the solenoid and cartridge drive) at least 10 times during the interrupted firing of 100 rounds. The machinegun shall be checked to assure that the firing stops immediately when the current to the solenoid is discontinued.

4.5.6.2.3 The machinegun shall be cooled to ambient temperature after each 200-round series using cooling aids other than water. The cyclic rate of fire shall be measured and recorded on each series. At the close of each day's firing, the machinegun shall be protected against corrosion. No parts shall be altered and only parts broken or worn to the extent that they are unserviceable shall be replaced.

4.5.6.2.4 Complete accurate records shall be kept for each reliability test, showing each malfunction and part replacement including the number of the round at which each occurred and corrective action taken.

4.5.7 Packaging tests.

4.5.7.1 Determination of cleanliness. The applicable surfaces (except for barrel bore and chamber) of each sample unit shall be subjected to the determination of cleanliness test in accordance with MIL-P-116, except that the wipe test shall not be applicable to parts with black oxide or anodized protective coatings. The barrel bores and chambers shall be wipe tested for cleanliness using clean white bore cleaning swabs, and the degree of cleanliness shall be verified by comparison of the test swabs with standard swab samples furnished by the contracting officer.

4.5.7.2 Heat seal. The level A sample unit packages shall be subjected to the heat seal test specified in MIL-P-116.

4.5.7.3 Vacuum retention.

4.5.7.3.1 The flexible barrier for the sample level A unit packages shall be sealed except for an opening in the seam at one corner to accommodate a tube or pipe which is connected to a vacuum producing apparatus (aspirator or vacuum pump). A sufficient vacuum shall be drawn to cause the flexible barrier to cling snugly to the enclosed item. Care shall be exercised to insure that an excessive amount of vacuum is not applied which might cause puncture or rupture of the barrier. Without releasing the vacuum, the final opening in the barrier shall be sealed.

4.5.7.3.2 Interpretation of results. After remaining undisturbed at room temperature for 2 hours, the barrier shall be examined to determine whether it is still taut and retracts against the item when drawn away and quickly released.

4.5.7.4 Manufacturer installed equipment. Manufacturer installed equipment packaged in heat sealed bags shall be subjected to the heat seal and quick leak tests specified in MIL-P-116.

5. PREPARATION FOR DELIVERY

5.1 Pilot pack. On each contract a pilot pack consisting of a complete and packed shipping container representing initial production shall be forwarded in accordance with 3.2.

5.2 Packaging data sheets. Quantity of machineguns (and equipment if applicable) per pack shall be as specified under "Logistic Data" on Packaging Data Sheets P8413999 or P7792090 as applicable. All other logistic data are for informational use only.

5.3 Preservation, packaging, packing, and marking. Machineguns and equipment shall be preserved, unit packaged, packed, and marked in accordance with the requirements of Packaging Data Sheets P8413999 or P7792090 as applicable. Level A and level B packs shall be capable of passing the free fall drop test (see 4.3).

5.4 Workmanship. Adequate controls shall be utilized to check for contamination of cleaning solvents and preservative oils. Heat seals shall be uniform in appearance. Sealing tape shall be applied to boxes uniformly and shall adhere to joints and seams.

6. NOTES

6.1 Ordering data. Procurement documents should specify the following:

- (a) Title, number, and date of this specification.
- (b) Lists of drawings and specifications pertinent to machinegun overhaul, showing applicable revision dates.
- (c) List of inspection equipment pertinent to machinegun overhaul, showing applicable revision dates.
- (d) Responsibilities for furnishing replacement parts (see 3.1).
- (e) Number of initial production samples required for tests (see 3.2).
- (f) That packages opened for examination shall be repackaged by the supplier at the supplier's expense.
- (g) Shipping instructions for initial production samples and pilot pack (see 3.2 and 5.1).
- (h) Selection of applicable levels of preservation, packaging, and packing.
 - (1) Level B preservation and packaging is intended to provide adequate and economical protection during multiple domestic shipments, handling, and indoor storage period up to 12 months from date of initial packaging (see 6.3).
- (i) Instructions for disposal of nonreparable parts (see 4.2.3.1.1).
- (j) Responsibilities and instructions for reworking reparable parts (see 4.2.3.2).
- (k) List of acceptance inspection equipment to be furnished the supplier (see 4.4.4.1) and responsibilities for other Government property to be furnished the supplier.
- (l) Responsibilities for furnishing ammunition and links (see 4.4.4.2).
- (m) Responsibility for test firing facilities and operating procedures (see 6.4).
- (n) Disposition of Government furnished property.
- (o) Disposition of equipment included with machineguns prior to overhaul.
- (p) Responsibilities for investigating cause of weapon failure to meet performance requirements.
- (q) Responsibilities for correcting cause of weapon failure to meet performance requirements.

6.2 Definitions of terms. Listed below are definitions of some of the special terms used in the inspection of small arms and as used in this specification:

Acceptable quality - That product characteristic which meets contractual requirements and resembles original manufacture in appearance.

Bur - A small jagged projection of metal deviating from normal contour.

Chipped - Having visual evidence of small pieces of material having been removed (usually on edges) due to extensive use or abuse.

Crack - Separation of material, usually due to extensive use or abuse, visually evidenced by a fine irregular line.

Deformation - Departure from original configuration as determined by comparison with materiel of known acceptable quality.

Erosion - Larger and more extensive form of pitting resulting in deterioration of surface areas or dimensions.

Known acceptable quality - The quality determined representative of materiel which has been approved for acceptance by a Government representative.

Manual examination - Use of hands, exerting reasonable average pressure, to detect motion or lack of motion.

Mutilation - Mark or displacement of material from original surface as determined by comparison with materiel of known acceptable quality.

Perceptible movement - Any movement visually or tactually evident.

Pit - A small irregular cavity normally found in areas contacted by corrosive gases during firing.

Relative movement - Any movement, visually or tactually perceptible, between two parts designed to be fixed by joining.

Seam - An unwelded fold on the surface of metal usually produced during rolling or forging. May appear to be a crack.

6.3 Level B preservation and packaging. Machineguns preserved and packaged in accordance with level B requirements must be inspected to determine condition when not used within a 1-year period. Machineguns not used within this period should be represerved and repackaged in accordance with this specification as determined necessary by storage conditions and anticipated storage time.

6.4 Test firing facilities and operating procedures should be designed by the supplier in conformance with local, state, and federal regulations. They should be suitable for carrying out prescribed firing tests and insure the safety of operating and visiting personnel. Copies of these supplier designs should be forwarded to the contracting officer. Government facilities may be viewed upon application to the contracting officer.

6.5 When action by a testing agency is required, work programing will be effected with the testing agency at the earliest practicable date.

6.6 To avoid delay in test firing, the Government representative should maintain a minimum of 2 months' supply of ammunition as determined by anticipated firing requirements.

6.7 Monthly reports of the results of final examination and functioning firing, targeting and accuracy, and reliability tests should be made to Commanding Officer, Springfield Armory, ATTN: SWESP-RES, Springfield, Massachusetts 01101, and to Commanding General, U. S. Army Weapons Command, ATTN: AMSWE-SMM and AMSWE-QA, Rock Island, Illinois 61202. (See Part 7 for applicable form).

6.8 The following paragraph should be included in the written contract to cover the type of quality assurance system that is desirable for this item:

Supplier's quality assurance system. The supplier shall provide and maintain a quality assurance system in accordance with MIL-I-45208.

6.9 The following data are presented for information and guidance only. Supplier may choose or modify details to suit his particular facilities. Drawings of tools, fixtures, or equipment can be furnished upon request to the contracting officer.

6.9.1 Shop layout.

6.9.1.1 The shop layout diagram shown in figure 3 is provided for assistance to suppliers in establishing a shop layout which will provide an expeditious and economical shop operation.

6.9.1.2 The basic machinegun moves through the production line through the various stages of disassembly, cleaning, inspection, reconditioning, assembly, and testing to final inspection and acceptance.

6.9.1.3 Shop layout will vary according to physical facilities available. However, shop operations should be established in a pattern similar to that shown in the diagram. The information in this section follows the pattern established by the shop layout diagram.

6.9.2 Overhaul flow chart. The overhaul flow chart, shown in figure 4, establishes a proper flow of work to provide an expeditious and economical shop operations.

6.9.3 Operations route sheet. The operations route sheet, table VI, supplements the overhaul flow chart (see figure 4). The operation numbers correspond to the numbers on the chart. Special and fabricated tools, equipment, and fixtures recommended for an operation are indicated opposite the operation. Detailed instructions for each of the operations are contained in pertinent sections covering the specific operation.

Table VI. - Operations route sheet

Operation number	Operation	Special and fabricated tools, gages, fixtures, and equipment
1	Unpack	
2	Degrease (Optional)	Vapor degreaser, process C-7 of MIL-P-116, for metal parts. Solvent tank, process C-3 of MIL-P-116, for rubber coated parts
3	Disassemble into major groups	
4	Disassemble major groups	Fixture, buffer disassembling and assembling (7269361) (see figure 21)
5	Reclean parts as required for inspection	Vapor degreaser for metal parts. Solvent tank for rubber coated parts.
6	Inspect barrel assembly	See applicable OIP, Rod, Cleaning, MI (6508237)
7	Inspect components visual, and gage	See applicable OIP
8	Repair and reclamation	Fixture, sear notch, operating rod (see figure 32). Fixture 10-012846, tighten or replace receiver rivets Fixture 10-011485 and 10-012221, tighten or replace side rail rivets Fixture 10-014290, tighten or replace lower rail rivets Fixture 10-011473, tighten or replace bottom rivet Fixture 10-014020, tighten or replace magazine bracket assembly rivets

Table VI - Operations route sheet (continued)

Operation number	Operation	Special and fabricated tools, gages, fixtures, and equipment
9	Refinish components	See section 3
10	Quality control verification	Refer to operations 6 and 7 above
11	Quality assurance verification	Refer to operations 6 and 7 above
12	Parts storage	See section 4
13	Assemble into major groups	Fixture, buffer disassembly and assembly (7269361) (see figure 21)
14	Assemble major groups	
15	Prefiring inspection	See section 4
16	Pressure resistance and function fire	See section 4
17	Minor repair	See troubleshooting guide (table VII)
18	Targeting and accuracy	See section 4
19	Minor repair	See troubleshooting guide (table VII)
20	Clean weapon	
21	Final inspection	See section 4
22	Preservation and packaging	See section 5
23	Packaging inspection	See section 4

6.9.4 Disassembly procedures.

6.9.4.1 Removal of major groups and assemblies.

6.9.4.1.1 M60 machinegun.

6.9.4.1.1.1 Barrel assembly with bipod assembly. To remove the barrel assembly (see figure 5(1)), the gun should be cocked and on safe. Raise the barrel lock lever at extreme right front of receiver to a vertical position and using bipod as a handle, withdraw the barrel from the receiver (see figure 7).

6.9.4.1.1.2 Trigger mechanism group.

- (a) Before removal of the trigger mechanism (see figure 5(2c)), the recoiling parts must be in battery position. Move safety to "fire" position. Pull the cocking handle all the way to the rear then squeeze the trigger and ease the recoiling parts to battery position. This will prevent damage to feed tray.
- (b) To remove the trigger mechanism group, press in on the front of the spring lock and rotate the front end down to clear it from the front trigger housing holding pin. Disengage the rear of the spring lock from the rear trigger housing holding pin.
- (c) For new style lock springs (see applicable OIP), the following procedure will be used. Press in on the rear of the spring lock and rotate the rear end up to clear it from the rear trigger housing holding pin. Disengage the front of the spring lock from the front trigger housing holding pin. Continue either procedure as follows: Remove the front trigger housing holding pin to the left. Slide the trigger housing forward slightly and rotate the front of the housing down and remove it from the receiver.

6.9.4.1.1.3 Butt stock assembly. To remove butt stock assembly (figure 5(3)), open shoulder rest, insert nose of dummy round, or a similar object, in aperture of the butt plate recess, and compress the latch that secures the stock. Pull rearward to remove the stock from buffer as shown in figure 8.

6.9.4.1.1.4 Forearm assembly. To remove forearm assembly (figure 5(4)), insert nose of dummy round, or a similar object, in aperture on the bottom of the forearm, compress the catch, as shown in figure 10, and slide the forearm forward off the receiver.

6.9.4.1.1.5 Cover assembly and tray assembly groups.

Note. The key numbers and letters shown below in parentheses refer to item 5, figure 5.

To remove the cover assembly (5D) turn lever assembly clockwise and raise cover to a vertical position. Unhook latch (5A) with dummy round, or similar object, and press out as shown in figure 11. Press out pin (5B). Lift cover (5D) and remove spring (5C). Lift tray assembly (5E) off the receiver.

6.9.4.1.1.6 Buffer and operating rod group. To remove buffer and operating rod group, hold the palm of the hand against the exposed end of the buffer assembly. Press slightly against the buffer with one hand and remove the retaining yoke from the top of the receiver with the other hand. Remove the buffer assembly, guide spring assembly, guide spring, and the operating rod assembly with bolt assembly from the butt end of the gun. To remove the operating rod and bolt, pull the cocking handle to the rear. Reach through the top of the receiver and push the bolt until one-half protrudes from the rear of the receiver.

Note. When removing the operating rod assembly, the bolt assembly (figure 5(7)) will automatically be removed. However, the bolt should not be completely removed from the guides until after the buffer retaining yoke (figure 5(6A)), is inserted in the cam slot. This retains the firing pin in a cocked position, making it easier to disassemble the bolt from the rod by slightly rotating the bolt toward the rod. If further disassembly of the bolt is required, remove the yoke, releasing the spring tension on the firing pin.

6.9.4.1.2 M60C machinegun.

6.9.4.1.2.1 Barrel assembly. To remove the barrel assembly, raise the barrel lock lever at the extreme right front of receiver to a vertical position. Pull handle of cocking handle assembly approximately 4 inches rearward (just clear of rear of solenoid housing) using barrel as a handle. Withdraw barrel assembly from the receiver, then ease the recoiling parts into battery position. This will prevent damage to the feed tray.

6.9.4.1.2.2 Firing actuator group. To remove firing actuator group (item 2 figure 6), follow procedure outlined in 6.9.4.1.1.2(c).

6.9.4.1.2.3 Backplate assembly and buffer assembly. To remove backplate assembly, turn cover latch assembly lever clockwise and raise cover to a vertical position. Insure that the recoiling parts are in battery position. With the palm of the hand against the rear of the backplate assembly, press slightly against the backplate and remove the retaining yoke from the top of receiver. Remove the backplate and buffer assembly from the butt end of the gun (see figure 9).

6.9.4.1.2.4 Cover assembly and tray assembly groups. To remove cover assembly and tray assembly, follow procedure outlined in 6.9.4.1.1.5.

6.9.4.1.2.5 Operating rod group and bolt assembly. Remove driving spring guide assembly, guide spring, and the operating rod assembly with bolt assembly from the butt end of the gun. To remove the operating rod and bolt, pull the cocking handle to the rear. Reach through the top of the receiver and push the bolt until one-half protrudes from the rear of the receiver, but do not separate bolt from operating rod. Insert buffer yoke (item 4 figure 6) in bolt cam slot. This will retain the firing pin in the cocked position to facilitate separation of bolt from rod. Pull bolt and rod out of receiver, slightly rotate bolt towards the rod, and remove bolt from rod. If further disassembly of the bolt is required, remove the yoke, releasing the spring tension on the firing pin.

6.9.4.2 Disassembly of major groups and assemblies.

6.9.4.2.1 M60 machinegun.

6.9.4.2.1.1 Barrel assembly with bipod assembly.

Note. The key numbers shown below in parentheses refer to figure 12.

The barrel assembly with bipod assembly shall be disassembled as follows:

- (a) Remove nut (4) and extension (5) from gas cylinder. Remove the two washers (6) from nut and extension.
- (b) Remove piston (7) from gas cylinder.
- (c) Remove plug (8) from gas cylinder.
- (d) When necessary to remove the flash suppressor (2) or bipod pivot hold as shown in figure 30, drill out pin halfway and then attempt to knock out pin. If unsuccessful, drill out remaining portion of pin from opposite side and unscrew flash suppressor from the barrel assembly.
- (e) Remove bipod assembly (3), when necessary.

6.9.4.2.1.2 Bipod assembly.

Note. The key numbers shown below in parentheses refer to figure 14.

The bipod assembly shall be disassembled as follows:

- (a) Remove screw (1) securing right-hand leg assembly (2) to pivot assembly (8).

- (b) Remove two rivets (2A) and key (2B) from right-hand leg assembly (2). Separate foot assembly (2C) from housing assembly (2D).
- (c) Remove pin (4) retainer (5), spring (6), and plunger (7) from housing assembly (2D).
- (d) Disassemble left-hand leg assembly (3) in accordance with (a) through (c) above.

6.9.4.2.1.3 Trigger mechanism group.

Note. The key numbers shown below in parentheses refer to figure 15.

The trigger mechanism group shall be disassembled as follows:

- (a) Remove pin (1), sear (2), plunger (3), and spring (4).
- (b) Remove safety (5), plunger (6), and spring (7).
- (c) Remove pin (8) and trigger assembly (9) from housing assembly (10).
- (d) When necessary to remove spring (9B), drill out stake and remove pin (9A) from trigger assembly and remove spring (9B) from trigger (9C).

6.9.4.2.1.4 Butt stock assembly.

Note. The key letters shown below in parentheses refer to item (3) in figure 5.

The butt stock assembly shall be disassembled as follows:

- (a) Bend down locking tabs on washer (B) and unscrew nut (A).
- (b) Remove washer (B) and swivel (C).

6.9.4.2.1.5 Forearm assembly.

Note. The key numbers shown below in parentheses refer to figure 17.

The forearm assembly shall be disassembled as follows:

- (a) Insert nose of dummy round or similar object in aperture of forearm and compress catch (3) until spring (1) is raised sufficiently to pry out by hand. Remove pin (2) and catch (3).
- (b) Bend down locking tabs on washer (5) and unscrew nut (4) remove washer (5) and swivel (6).

6.9.4.2.1.6 Cover assembly.

Note. The key numbers shown below in parentheses refer to figure 18.

The cover assembly shall be disassembled as follows:

- (a) Press retainer (1A) away from pivot and remove feed cam assembly (1) from cover assembly. With plunger (1B) compressed, remove retainer, plunger, and spring (1C) from channel (1D).
- (b) To remove lever assembly (2) push clip (2A) away from the pivot and lift up. Separate clip from feed lever (2B).
- (c) Remove snap ring (3) from pin (4) and remove pin. Press down on front and rear cartridge guides (5) and (6) and slide towards the center and lift up.
- (d) Pivot pawl assembly (7) into T-slot of housing assembly and remove. Press shaft (7A) from chassis (7D) and separate pawl (7B) and spring (7C) from chassis.

Note. The key letters in parentheses in (e), (f), and (g) below refer to item (8) figure 18.

- (e) When necessary to remove lever (A) remove stake from end of shaft portion of lever (A) and remove lever, latch, (B), spring (C), and pin (D) from housing assembly (8). Lever will be disposed of as scrap.
- (f) When necessary to remove bumper assembly (F), pad assembly (H), and shield (J), remove two rivets (E) and bumper assembly (F). Remove the nine rivets (G), pad assembly (H), and shield (J).
- (g) When necessary to replace stud (K) and spring (L), remove stud (K), spring (L), and washer (M) from frame assembly (N). Above rivets and the two studs will be disposed of as scrap.

6.9.4.2.1.7 Feed tray assembly.

Note. The key numbers shown below in parentheses refer to figure 19.

The feed tray assembly shall be disassembled as follows:

Drift shaft (1) out of frame (5) releasing rollers (2), and pawl (3), and spring (4).

6.9.4.2.1.8 Buffer assembly.

Note. The key numbers shown below in parentheses refer to figure 20.

The buffer assembly shall be disassembled as follows:

- (a) Place buffer assembly in fixture shown in figure 22. Tighten assembling tool, utilizing a small arbor press and compress buffer assembly until spring load

on pin (1) is removed. Rotate cover counterclockwise as depicted in figure 22. Remove pin. Slowly release pressure and then remove following components: cover (2), springs (3 and 4), cap (5), packing (6), springs (7 and 8), pads (9), plunger (10), gasket (11), and housing (12).

- (b) When tool 7269361 figure 21 is used place buffer assembly in assembling tool. Tighten assembling tool, compressing buffer assembly until spring load on pin (1) is removed. Rotate cover counterclockwise. Remove pin. Loosen tool, decompressing buffer assembly, and remove components detailed in (a).

6.9.4.2.1.9 Operating rod assembly.

Note. The key numbers shown below in parentheses refer to (6E) in figure 5.

The operating rod assembly shall be disassembled as follows:

Drive out pin (1) and remove roller (2).

6.9.4.2.1.10 Bolt assembly.

Note. The key numbers shown below in parentheses refer to figure 23.

The bolt assembly shall be disassembled as follows:

Align holes in actuator (3) with lock pin (1) and push out pin. Unscrew plug (2) and remove spring (4), bearing (5), and firing pin (6). With 3/32 inch punch remove pin (7) making sure ejector (8) and spring (9) do not fly out. Compress plunger (11), press extractor (10) toward plunger and remove extractor and spring (12) from bolt (13).

6.9.4.2.1.11 Receiver group.

Note. The key numbers shown below in parentheses refer to figure 24.

The receiver group shall be disassembled as follows:

- (a) Drive the sight assembly (1) out of the slotted portion of the receiver as shown in figure 26.
- (b) Drive pin (2) out of ring (3). Remove handle (4), plunger (5), and spring (6).
- (c) Depress retainer and remove pin (7), retainer (8), spring (9), plunger (10), lever (11), and shaft (12).

- (d) Remove screw (13) and guide (14). Slide handle assembly (15) to the rear of the guide slot and remove. Depress spring (15C), remove retainer (15A) and spring (15C) from slide (15D).

Note. Old style handle assemblies which contain plunger (7269238) and spring (7269240) will be disassembled as follows: Depress plunger and remove retainer, plunger, and spring from slide. Plunger and spring will then be discarded and will be replaced by spring (7791522).

- (e) Remove rivets (16) and bracket group (17).
In addition, the following disassembly may be necessary, for repairs.

Note. The key numbers shown below in parentheses refer to figure 27.

- (f) Remove two rivets (1) and plate (2) from receiver assembly (6).
- (g) Remove the two retaining pins (3) and rear mounting pin (4) from receiver.
- (h) Remove front mounting pin (5) from receiver.

6.9.4.2.1.12 Rear sight assembly.

Note. The key numbers shown below in parentheses refer to figure 28 and the letters refer to item (4) in figure 28.

The rear sight assembly shall be disassembled as follows:

- (a) Remove rivet (1), screw (2) and slide (3). Separate leaf assembly (4) from base and lateral knob assembly (5) and remove the two balls (6) and two springs (7).

When further disassembly may be necessary for repairs:

- (b) Remove the two rivets (A) and (B) and cap (C) from leaf (P).
- (c) Remove release assembly (D) and separate spring (E) from slide (F).
- (d) Remove screw (G), knob (H), ball (J), and the two springs (K) and (L) from leaf.
- (e) Remove screw (M) and scale (N).
- (f) Drill out stake on sleeve (5A) and remove knob (5B), ball (5C), and springs (5D) from base (5E).

6.9.4.2.1.13 Magazine bracket assembly.

Note. The key numbers shown below in parentheses refer to figure 29.

The magazine bracket assembly shall be disassembled as follows:

Disassemble the bracket group by removing rivets (1), spring (2), clips (3), pins (4), latches (5 and 6), and springs (7) from bracket (8).

6.9.4.2.2 M60C machinegun.

6.9.4.2.2.1 Barrel assembly.

Note. The key numbers shown below in parentheses refer to figure 13.

The barrel assembly shall be disassembled as follows:

- (a) Remove nut (3) and extension (6) from gas cylinder. Remove the two washers (4) from nut and extension.
- (b) Remove piston (5) from gas cylinder.
- (c) Cut wire and remove gas cylinder plug and extension locking wires (1).
- (d) Remove plug (2).
- (e) When necessary to remove the flash suppressor, follow procedure outlined in 6.9.4.2.1.1(d).

6.9.4.2.2.2 Firing actuator group.

Note. The key numbers shown below in parentheses refer to figure 16.

The firing actuator group shall be disassembled as follows:

- (a) Remove rear retaining pin (4), sear (1), sear compression spring (3) and sear plunger (2) from housing (5).
- (b) Cut and remove locking wires (9), unscrew and remove bolt (8), clinching rim flange (7), and solenoid (6).

6.9.4.2.2.3 Cover assembly. The cover assembly shall be disassembled following procedure outlined in 6.9.4.2.1.6.

6.9.4.2.2.4 Feed tray assembly. The feed tray assembly shall be disassembled following procedure outlined in 6.9.4.2.1.7.

6.9.4.2.2.5 Buffer assembly. The buffer assembly shall be disassembled following procedure outlined in 6.9.4.2.1.8.

6.9.4.2.2.6 Operating rod assembly. The operating rod assembly shall be disassembled following procedure outlined in 6.9.4.2.1.9.

6.9.4.2.2.7 Bolt assembly. The bolt assembly shall be disassembled following procedure outlined in 6.9.4.2.1.10.

6.9.4.2.2.8 Receiver group. The receiver group shall be disassembled following procedure outlined in 6.9.4.2.1.11(c) thru (d). In addition remove deflector (item 19 figure 25). Continue disassembly procedure outlined in 6.9.4.2.1.11(e) thru (h).

6.9.4.2.2.9 Magazine bracket assembly. The magazine bracket assembly shall be disassembled following procedure outlined in 6.9.4.2.1.13.

6.9.5 Cleaning.

6.9.5.1 Metal components. Metal components (not rubber covered) can be cleaned using process C-7 of MIL-P-116. Components containing heavy carbon residue can be further cleaned using process C-11 (or equal) of MIL-P-116.

6.9.5.2 Rubber covered components. Rubber covered components can be cleaned using process C-3 of MIL-P-116.

6.9.6 Repair. Rough spots, scores, burs, galling and gouges may be smoothed by filing, stoning, polishing or machining operations, so that the part will efficiently perform its normal functions. The degree of surface roughness of the repaired part surface should approximate that of original finish. In performing any of these operations, critical dimensions should not be altered.

6.9.6.1 M60 machinegun.

6.9.6.1.1 Barrel assembly with bipod assembly. The flash suppressor should be removed only when the flash suppressor or the bipod pivot has been determined to be defective (see applicable OIP and 6.9.4.2.1.1(d)).

6.9.6.1.2 Butt stock assembly. The swivel should be removed only when the washer, nut, or swivel has been determined to be defective (see applicable OIP and 6.9.4.2.1.4). The following repair method can be applied to reclaim those butt stock assemblies determined to be defective due to looseness of the hinge butt plate (see applicable OIP):

- (a) Drill out staked rivets from right side.
- (b) Knock out rivets.
- (c) Remove butt plate from butt stock.
- (d) Wire brush to clean butt stock.
- (e) Weld from inside, filling elongated hole with weld material and create a pad 1/16 to 1/8 inch thick as shown in step 1, figure 31. Use the inert-gas electric-arc process (with nonconsumable electrode) and 4043 or 5356 aluminum alloy filler metal.
- (f) Remove excess weld on outside flush to side of butt stock.

- (g) Using butt plate holes as a guide, and holding butt plate and butt stock firmly together, drill four holes as shown in steps 2 and 3 of figure 31. Remove butt plate and finish drill the two small holes, as shown in step 4 of figure 31.
- (h) Assemble butt plate to butt stock by riveting, using rivet 7269310.
- (i) Remove sharp edges left by riveting.

6.9.6.1.3 Forearm assembly. The swivel should be removed only when the washer, nut, or swivel has been determined to be defective (see applicable OIP and 6.9.4.2.1.5).

6.9.6.2 M60C machinegun.

6.9.6.2.1 Barrel assembly. The flash suppressor should be removed only when it has been determined to be defective (see applicable OIP and 6.9.4.2.1.1 (d)).

6.9.6.2.2 Solenoid assembly. Solenoid assemblies with rejected cables (see applicable OIP) but otherwise serviceable, can be corrected in the following manner:

- (a) Figure 35 depicts items involved in repairing solenoids.
- (b) Cut off cable at the grommet and cable junction, figure 36.
- (c) Remove and discard items 1 thru 8, figure 37.
- (d) Redrill and tap four holes, figure 41, using a bottoming tap.
- (e) Remove approximately 5/16 inch of the solenoid conductor insulation in preparation for applying the conductor splice, figure 38.
- (f) A continuity and resistance check shall be made on the solenoid, prior to crimping of the cable conductors to the solenoid conductors, to insure proper identification of the solenoid conductors, view A and view B of figure 42.
- (g) Cut cable conductors, approximately 1 inch long, and remove the insulation, approximately 5/16 inch, figure 38.
- (h) Place heat shrinkable tubing approximately 3/4-inch long, on cable conductors, figures 37 and 38.

Note: Do not apply heat at this time.

- (i) Make two parallel type splices; one connecting the "0" VDC solenoid with the "0" VDC cable conductor and one connecting the "+28" VDC solenoid conductor with the "+28" VDC cable connector, figure 38.

- (j) A continuity and resistance check shall be made on the cable connector pins, after crimping of the solenoid to the cable conductors, to insure proper assembly of the cable prior to applying heat to the heat shrinkable tubing, view A and B of figure 43.
- (k) Slide the heat shrinkable tubing in place over the splice. The heat shrinkable tubing shall cover the splice plus any exposed wire.
- (l) Apply heat, approximately 325° F, to the heat shrinkable tubing, figure 39. Heat may be applied to heat shrinkable tubing by the following methods:
 - (1) Soldering iron or gun, figure 39.
 - (2) Match.
 - (3) Benzomatic torch.
 - (4) Hot air gun.

A source of supply for item (4). Part No. HG-1 is:
Alpha Wire Corporation
200 Varick Street
New York 14, N.Y.
- (m) Assemble the cable to the solenoid and lockwire in place, figure 40.

6.9.6.3 M60 and M60C machineguns.

6.9.6.3.1 Cover assembly. The latch assembly should be removed only when the latch, lever, spring, pin, or cheek pad has been determined to be defective (see applicable OIP and 6.9.4.2.1.6 (e through g)). Welding of the covers having the hinge with only three rivets shall be accomplished in the following manner:

- (a) Clean surface to be welded and remove phosphate finish.
- (b) Weld using inert-gas electric-arc process (with non-consumable electrode) and a welding rod conforming to type MIL-310 of MIL-E-19933.
- (c) Clean assembly.
- (d) Refinish assembly by spray painting according to 3.3.1.4.

6.9.6.3.2 Housing assembly buffer. Epoxy sealer determined to be defective (see applicable OIP) shall be removed, and a new coating of epoxy adhesive conforming to MIL-A-52194 applied as depicted in figure 33.

6.9.6.3.3 Tube buffer. Markings determined to be defective or missing (see applicable OIP) shall be remarked by the electrolytic stencil process as depicted in figure 34. An approved source is:

The Lectroetch Co.
14925 Elderwood Ave.
Cleveland 12, Ohio

Other methods for application of markings can be utilized with prior approval of the responsible technical agency.

6.9.6.3.4 Receiver assembly. Receivers with missing or improper weld (see applicable OIP), but otherwise serviceable, can be welded in the following manner:

- (a) Clean surface to be welded and remove phosphate finish.
- (b) Weld single pass fillet 1/8 inch by 3/4 inch as depicted on page 3 of applicable OIP, using inert-gas electric-arc process (with nonconsumable electrode) and a 3/32 inch diameter welding rod conforming to type MIL-310 of MIL-E-19933.
- (c) Clean assembly.
- (d) Refinish assembly.

6.9.6.3.4.1 Receiver assembly. Receivers with missing ramp angle modification (see applicable OIP) can be modified as follows.

- (a) Remove barrel assembly, trigger mechanism, butt stock assembly, forearm assembly, buffer and operating rod group, bolt, cover assembly, and feed tray assembly from receiver.
- (b) Make sure that barrel hole in receiver is clean and free of excess oil. Position receiver in vise as shown in Figure 49 and clamp securely.
- (c) Insert adaptor into barrel hole and **seat** fully. Make sure that the slot in the adaptor shank is in a vertical orientation, and rotate barrel locking lever 90 degrees rearward to the locked position.
- (d) Position the guide block above the receiver and lower vertically into slot in adaptor shank.
- (e) Insert pin into and through holes in the adaptor shank and guide block to fix the components in position.
- (f) Secure cutter assembly in drill chuck, lubricate cutter with heavy oil, and insert into bushing in guide block.
- (g) Start drill and proceed to cut ramp angle. Revolutions per minute (RPM's) must not exceed 250 RPM's with or without a load applied. RPM's greater than 250 will reduce cutter life.

CAUTION: Care must be exercised to maintain steady pressure and to hold the drill and cutter assembly at the proper angle. Exerting pressure one way or another, or allowing the drill to sag, will create an undesirable binding condition. The stop on the cutter assembly is located approximately 3 7/8 inches from the front of the cutter to the front of the stop and this dimension should be periodically checked to insure that the 3 7/8 inch dimension is maintained.

- (h) Remove cutter assembly and take out pin, guide block and adaptor assembly.
- (i) Brush or wipe out inside of receiver.

- (j) Insert adaptor assembly into barrel hole in receiver and lock in position with barrel locking lever.
- (k) Insert gaging plug Figure 49 into hole in adaptor and check new bullet ramp angle using the following procedure (see Figure 50).
 - Step 1 - With "Not Go" facing up, the plug must not enter receiver.
 - Step 2 - With "Go" facing up, the plug must enter until notch is in line with the receiver.
 - Step 3 - With "Not Go" No. 1 facing up, the plug must not be able to be pulled out of receiver.
 - Step 4 - With "Not Go" No. 3 facing up, the plug must not be able to be pulled out of receiver.
- (l) Upon satisfactory completion of the modification of the bullet ramp angle, receivers shall be identified by stamping the letter "R" after the weapon serial number. The letter "R" shall be 3/16 inch high.

6.9.6.3.5 Guide assembly. When undercut (see applicable OIP) has been determined to be missing and the guide assembly is otherwise serviceable, it shall be repaired in the following manner:

- (a) Insert rod in lathe chuck and secure.
- (b) *See Ch #6 for ref.* ~~Using a 3/16 inch two lip end mill,~~ recut rod to dimension and requirements shown in figure 44. *"Machining method optional"*
- (c) Remove from lathe.
- (d) Remove burs.

6.9.6.3.6 Operating rod. Grind sear notch as shown in figure 32 (see applicable OIP).

6.9.6.3.7 Operating rod assembly. Rod operating assemblies determined to be unacceptable due to small retaining pin hole but otherwise serviceable, shall be modified in the following manner:

- (a) Remove and discard pin and roller.
- (b) Ream pin hole to dimensions specified (see figure 45).
- (c) Remove burs.
- (d) Install roller (7790942) in yoke of operating rod assembly, insert pin (7790941), and stake yoke material over pin.

Note. Staking must be from the forward (gas cylinder) end of the operating rod assembly.

- (e) Roller shall rotate without binding (see 3.3.3.6.2 and 3.3.4.3.2).

6.9.6.3.8 The following solid film lubricant has been used satisfactorily for refinishing of the feed pawl assembly and the buffer plunger guide (see 3.3.1.2):

Electrofilm Lubri-Bond "A"
Electrofilm, Inc.
7116 Laurel Canyon Blvd.
North Hollywood, California

6.9.6.3.9 The following lubricant has been used satisfactorily on the buffer plunger shaft and packing (see 3.3.2.3):

Parker O-Lube
Parker Appliance Co.
Cleveland, Ohio

6.9.7 Assembly procedures.

6.9.7.1 Assembly of major groups and assemblies.

6.9.7.1.1 M60 machinegun.

6.9.7.1.1.1 Bipod assembly.

Note. The key numbers shown below in parentheses refer to figure 14.

The bipod assembly shall be assembled as follows:

- (a) Insert the foot assembly (2C) into the housing (2D) of the right-hand leg assembly (2).
- (b) Position key (2B) in housing assembly.
- (c) Install the two rivets (2A) through the holes in the housing, key, and foot retainer springs and rivet securely.
- (d) Assemble the plunger (7), spring (6), retainer (5), and pin (4).
- (e) Assemble right-hand leg assembly to pivot assembly (8) with screw (1) and stake securely.
- (f) Assemble left-hand leg assembly (3) in accordance with (a) through (e) above.

6.9.7.1.1.2 Barrel assembly.

Note. The key numbers shown below in parentheses refer to figure 12.

The barrel assembly shall be assembled as follows:

- (a) Assemble plug (8) into the gas cylinder with a torque of 5 to 15 pound-feet.
- (b) Assemble washer (6) to extension (5) and screw into front end of gas cylinder.
- (c) Insert piston (7) into gas cylinder.
- (d) Assemble washer (6) to nut (4) and screw into rear end of gas cylinder.
- (e) When necessary install bipod assembly (3) on barrel assembly (9). Screw flash suppressor (2) on barrel until the bipod yoke binds. Unscrew flash suppressor until bipod assembly pivots freely and one prong is at the 6 o'clock position, the gap between the bipod yoke and flash suppressor should be about 0.020 inch. Using a 1/8-inch drill and the flash suppressor holes as a guide, drill through and install a 1/8-inch diameter by 3/4-inch long spring pin. Stake securely on both ends. When using a new flash suppressor, use a #31 drill and the flash suppressor holes as a guide, drill through and install pin (1). Stake securely on both ends.

6.9.7.1.1.3 Trigger mechanism group.

Note. The key numbers shown below in parentheses refer to figure 15.

The trigger mechanism group shall be assembled as follows:

- (a) When necessary, assemble spring (9B) and pin (9A) to trigger (9C) and rivet securely. Both ends of pin must be flush or below sides of trigger.
- (b) Assemble trigger assembly (9), pin (8), spring (7), plunger (6), safety (5), spring (4), plunger (3), sear (2), and pin (1) into housing assembly (10).

6.9.7.1.1.4 Butt stock assembly.

Note. The key letters shown below in parentheses refer to item 3 in figure 5.

The butt stock assembly shall be assembled as follows:

When necessary, insert swivel (C) in hole on bottom forward end of frame (D) position washer (B) over swivel and tighten nut (A). Bend locking tabs of washer against nut.

6.9.7.1.1.5 Forearm assembly.

Note. The key numbers shown below in parentheses refer to figure 17.

The forearm assembly shall be assembled as follows:

- (a) When necessary, insert swivel (6) in hole on bottom forward end of cover (7), position washer (5) over swivel and tighten nut (4). Bend locking tabs of washer against nut.
- (b) Insert catch (3) in yoke within cover and align holes. Insert pin (2) and snap the spring (1) in position with longer portion of spring up. Tangs of springs will engage recesses in the forearm and the catch.

6.9.7.1.1.6 Cover assembly.

Note. The key letters shown below in parentheses refer to item 8 in figure 18.

The cover assembly shall be assembled as follows:

- (a) When necessary, place washer (M), spring (L) on stud (K) and rivet securely to frame assembly (N). Repeat for other stud.
- (b) Position shield (J) and pad assembly (H) on frame assembly and rivet in place with nine rivets (G). Position bumper assembly (F) and rivet in place with two rivets (E).

Caution. The rivet adjacent to the rear of the ejection port shall be flush on the inside. The inside surface of shield and outside surface of frame assembly shall be flush after riveting.

- (c) Assemble pin (D), spring (C), latch (B), and lever (A) to housing assembly (8). Spin over securely the hollowed out portion of the shaft to the housing assembly. Shaft must rotate freely after assembly.

Note. The key letters shown in parentheses in (d) and (e) below refer to item 7 in figure 18, the numbers refer to figure 18.

- (d) Assemble spring (C), pawl (B), and shaft (A) to chassis (D). Position pawl assembly (7) into T-slot of housing assembly (8).
- (e) Position front cartridge guide (5) and rear cartridge guide (6) on top of washer on their respective studs, press down and slide into assembled position. Insert shaft (4) (hole end first) and secure with cotter pin (3).

Note. The key letters shown in parentheses in (f) below refer to item 2 in figure 18.

(f) Assemble clip (A) to feed lever (B). Position lever assembly (2) on pivot and lock in position with clip.

Note. The key letters shown in parentheses in (g) below refer to item 1 in figure 18.

(g) Assemble spring (C) and plunger (B) to channel (D). Place channel on pivot, depress plunger, position channel on pivot and insert retainer (A).

6.9.7.1.1.7 Feed tray assembly.

Note. The key numbers shown below in parentheses refer to figure 19.

The feed tray assembly shall be assembled as follows:

Assemble spring (4), pawl (3), and roller (2) into frame (5), align holes and insert shaft (1).

6.9.7.1.1.8 Buffer assembly.

Note. The key numbers shown below in parentheses refer to figure 20.

The buffer assembly shall be assembled as follows:

Insert gasket (11) in housing (12) and place in buffer assembling tool. Insert plunger (10) through hole in housing and pads (9) with rubber surfaces facing metal of plunger head. Insert springs (8 and 7), packing (6), and cap (5). Insert springs (4 and 3) into cover and cap. Compress buffer assembly and insert pin to lock components of buffer assembly. Rotate cover clockwise. Release and remove buffer assembly from the tool.

6.9.7.1.1.9 Operating rod assembly.

The operating rod assembly shall be assembled as follows:

Position roller in yoke of operating rod assembly, insert pin, and stake yoke material over pin.

Note. Staking must be from the forward (gas cylinder) end of the operating rod assembly.

Note. Roller shall rotate without binding (see 3.3.3.6.2 and 3.3.4.3.2).

6.9.7.1.1.10 Bolt assembly.

Note. The key numbers shown below in parentheses refer to figure 23.

The bolt assembly shall be assembled as follows:

- (a) Insert spring (12), plunger (11), and extractor (10) into bolt (13).
- (b) Insert spring (9) and ejector (8) into bolt. Compress ejector, insert spring pin (7).

Note. Pin must be inserted from top of bolt (13) when bolt is in cocked or rearward position.

- (c) Insert firing pin (6), bearing (5), and spring (4). Position actuator (3) over end of bolt, insert plug (2), and tighten sufficiently to align with holes in actuator and bolt. Insert pin (1) until actuator can rotate freely.

6.9.7.1.1.11 Rear sight assembly.

Note. The key letters shown below in parentheses refer to item 5 in figure 28.

The rear sight assembly shall be assembled as follows:

- (a) Place the spring (D) into base (E) and position ball (C) on top of spring. Assemble knob (B) and sleeve (A) to base making sure that the detent ball and spring are in place.

Note. The letters shown in parentheses in (b) through (e) below refer to item 4 in figure 28.

- (b) Position scale (N) and secure with screw (M) on leaf (P).
- (c) Position the two springs (L) and (K) in their respective recesses and install ball (J), knob (H), and screw (G).
- (d) Assemble slide (F), spring (E), release assembly (D), and install on leaf.
- (e) Place cap (C) on top of leaf, and insert rivets (B) and (A). Upset ends of the two rivets on the front side of leaf (as installed on machinegun).

Note. The numbers in parentheses in (f) and (g) below refer to figure 28.

- (f) Position the two springs (7) and the two balls (6) on the end coils and place the leaf assembly directly on top of the base (5). With slide (3) in place, position the leaf assembly on the base and insert screw (2) through the sleeve, leaf and slide.

- (g) If a new windage screw is installed, position leaf assembly and slide tightly against end of thread on windage screw. Drill a $0.078 + 0.002$ inch diameter hole through the windage screw, using the hole in the slide as a guide. Insert rivet (1) and stake in place.
- (h) If a used windage screw is used, selective assembly may be resorted to in order to control the amount of lateral movement of leaf assembly within the base assembly. Maximum lateral movement permitted after assembly shall not exceed 0.015 inch.
- (i) After assembly, the elevating and windage components shall function freely and with distinct clicks.

6.9.7.1.1.12 Receiver group.

The receiver group shall be assembled as follows:

Note. The key numbers in parentheses in (a) below refer to figure 29.

- (a) Assemble the bracket group by inserting springs (7) into latches (6 and 5) and positioning latches on bracket (8); insert pins (4), secure with cotter pins (3) and fasten spring (2) with rivets (1).

Note. The key numbers in parentheses in (b) through (f) below refer to figure 24 unless otherwise indicated.

- (b) Secure bracket group (17) to receiver (18) with rivets (16).
- (c) Insert spring (15C) into slide (15D). Depress spring and insert retainer (15A). Insert handle assembly (15) into guide slot on receiver and slide to the forward or locked position. Position guide (14) and secure with screw (13).
- (d) Insert shaft (12). Slip lever (11) over shaft and insert plunger (10), spring (9), and retainer (8). Rotate lever until plunger seats in shaft hole. Align holes in retainer and lever, depress retainer and insert pin (7).
- (e) Insert spring (6), plunger (5), and handle (4). Position ring (3) and insert pin (2).
- (f) Position sight assembly (1) in dovetail slot of receiver (see figure 26) target weapon and stake base of sight and receiver in four places.

Note. The key numbers shown in parentheses in (g) through (j) below refer to figure 27.

- (g) Install the front mounting pin (5) on receiver (6) and stake securely at both ends.
- (h) Install the rear mounting pin (4).

- (i) Install the two retaining pins (3) in rear mounting pin and stake securely.
- (j) Install plate (2) on receiver with the two rivets (1).

6.9.7.1.2 M60C machinegun.

6.9.7.1.2.1 Barrel assembly.

Note. The key numbers shown below in parentheses refer to figure 13 except as noted.

The barrel assembly shall be assembled as follows:

- (a) Assemble plug (2) into bottom of gas cylinder with a torque of 5 to 15 pound-feet, insert wire (1) and secure. Continue assembly using procedure outlined in 6.9.7.1.1.2(b) through (d).
- (b) When the flash suppressor has been removed, it shall be assembled by screwing it onto the barrel until secure. (A 0.040 inch maximum gap between shoulder of barrel and flash suppressor is permissible). Continue drilling and assembly procedure as outlined in 6.9.7.1.1.2(e).

6.9.7.1.2.2 Firing actuator group.

Note. The key numbers shown below in parentheses refer to figure 16.

The firing actuator group shall be assembled as follows:

- (a) Assemble housing (5) to solenoid (6) with spring well of housing to the rear of solenoid. Secure clinching rim flange (7) by screwing bolt (8) into housing (5) and install wire (9) through nut (8) and secure.
- (b) Assemble sear plunger spring (3) sear plunger (2) into spring well of housing (5) compress spring and plunger with sear (1) insert rear retaining pin in housing (5) through sear (1) from left to right.

6.9.7.1.2.3 Cover assembly. The cover assembly shall be assembled following procedure outlined in 6.9.7.1.1.6.

6.9.7.1.2.4 Feed tray assembly. The feed tray assembly shall be assembled following procedure outlined in 6.9.7.1.1.7.

6.9.7.1.2.5 Buffer assembly. The buffer assembly shall be assembled following procedure outlined in 6.9.7.1.1.8.

6.9.7.1.2.6 Operating rod assembly. The operating rod assembly shall be assembled following procedure outlined in 6.9.7.1.1.9.

6.9.7.1.2.7 Bolt assembly. The bolt assembly shall be assembled following procedure outlined in 6.9.7.1.1.10.

6.9.7.1.2.8 Receiver group. The receiver group shall be assembled following procedure outlined in 6.9.7.1.1.12(a) through (e) and (g) through (j). In addition, deflector (item 19, figure 25) shall be assembled by inserting prongs between bracket assembly and receiver, applying downward pressure until deflector fits into place.

6.9.7.2 Installation of major groups and assemblies.

6.9.7.2.1 M60 machinegun.

6.9.7.2.1.1 Forearm assembly. The forearm assembly shall be installed as follows:

Fit forearm assembly over front of receiver, slide rearward, and press into position until catch locks in position within slot on bottom of receiver.

6.9.7.2.1.2 Barrel assembly with bipod assembly. The barrel assembly with bipod assembly shall be installed as follows:

Raise locking lever to a vertical position. Insert barrel assembly into receiver and lock barrel by moving the locking lever to the horizontal position.

6.9.7.2.1.3 Buffer and operating rod group. The buffer and operating rod group shall be installed as follows:

Place the camming yoke of the operating rod assembly into the bolt assembly and remove the buffer retaining yoke.

Note. When the bolt has been removed from the receiver without inserting the buffer retaining yoke, the bolt and rod will be assembled by an alternate method. Insert the yoke of the rod into the bolt, engaging the rear spool of the firing pin. With a rearward movement, rotate the yoke and firing pin, causing the bolt to rotate to the left in a cocked position. With the bolt in this position and the firing pin spring compressed, insert the bolt and rod into the receiver. Insert the spring and guide into the rear of the receiver, taking precaution that the spring is inserted in the operating rod. Push forward until bolt is in battery position. Insert buffer and lock in place with buffer retaining yoke.

6.9.7.2.1.4 Butt stock assembly. The butt stock assembly shall be installed as follows:

Position butt stock assembly on rear of receiver, push forward until latch secures butt stock assembly to buffer assembly.

6.9.7.2.1.5 Cover assembly and tray assembly groups. The cover assembly and tray assembly groups shall be installed as follows:

Position cartridge feed tray assembly on receiver so the two arms with holes are upright. Position torsion spring between lugs of cover assembly assuring that one tang of spring is inserted into hole of cover assembly. Position cover so that it is perpendicular to receiver, insert lugs on cover between lugs on receiver and guide tang of torsion spring into small hole in receiver. Insert cover hinge pin from right to left, insert hinge pin latch into left end of cover to lock in place.

6.9.7.2.1.6 Trigger mechanism group. The trigger mechanism group shall be installed as follows:

Position notched lug of trigger mechanism assembly in slot on bottom of receiver and raise mechanism to align with holes in the receiver. Insert retaining pin through holes and secure mechanism to the receiver by attaching lock spring to the retaining pins.

6.9.7.2.2 M60C machinegun.

6.9.7.2.2.1 Barrel assembly. The barrel assembly shall be installed following procedure outlined in 6.9.7.2.1.2.

6.9.7.2.2.2 Operating rod group and bolt assembly. The operating rod group and bolt assembly shall be installed following procedure outlined in 6.9.7.2.1.3 except that the buffer assembly and buffer retaining yoke shall not be installed at this time.

6.9.7.2.2.3 Backplate assembly and buffer assembly. The backplate assembly and buffer assembly shall be installed as follows:

Insert buffer assembly, buffer cap first, inside backplate assembly, and secure the buffer by inserting the buffer cap into the buffer retaining recess provided for in the backplate. Insert the

buffer plunger into the head of driving spring guide. Position backplate assembly on receiver assembly and push forward until buffer retaining yoke can be inserted through the top of the receiver securing buffer assembly to receiver assembly.

6.9.7.2.2.4 Cover assembly and tray assembly groups. The cover assembly and tray assembly groups shall be installed following procedure outlined in 6.9.7.2.1.5.

6.9.7.2.2.5 Firing actuator group. The firing actuator assembly shall be installed following procedure outlined in 6.9.7.2.1.6 except that firing actuator assembly will be substituted for trigger mechanism assembly where applicable.

6.9.7.3 Trigger pull (applicable to M60 machinegun only). Check trigger pull (see 4.5.2 and figure 46). If trigger pull is not within specified limits, correct by selective assembly of operating rod assembly, trigger assembly, sear, or sear plunger and spring.

6.9.8 Malfunctions. Table VII lists the malfunctions most commonly observed in the course of firing. Each malfunction is listed, followed by the principal causes for the faulty condition and the corrective action to be taken.

Table VII - Troubleshooting guide

Malfunction	Probable cause	Corrective action
Failure to feed	Insufficient gas pressure.	Clean gas port.
	Damaged or worn gas cylinder or piston.	Replace .
	Damaged or worn cartridge feed tray components.	Replace.
	Feed pawl defective.	Replace.
	Feed pawl spring defective.	Replace.
	Front and rear cartridge guides defective.	Replace.
	Feed lever cam spring.	Replace.

Table VII - Troubleshooting guide (continued)

Malfunction	Probable cause	Corrective action
Failure to feed.	Feed cam assembly deformed or bent.	Replace.
	Feed cam lever bent or malformed at any pivot point.	Replace.
	Feed cover housing assembly bent or dented.	Replace.
	Operating rod roller and pin worn or damaged.	Replace.
	Bolt cam actuator roller defective.	Replace.
	Lubrication inadequate.	Apply lubricant as required.
	Defective link or ammunition.	Insert new ammunition or link.
	Ammunition belt installed wrong.	Reverse belt with open portion of link down.
	Defective cover latch or cover latch spring.	Replace.
	Damaged or weakened operating rod spring.	Replace.
Failure to chamber	Obstruction by foreign substances or material in receiver.	Remove item blocking movements, clean and lubricate as required.
	Cartridge guide springs weak or broken.	Replace.

Table VII - Troubleshooting guide (continued)

Malfunction	Probable cause	Corrective action
Failure to chamber.	Front cartridge guide worn at point of link contact.	Replace.
	Cartridge retainer pawl worn.	Replace.
	Cartridge feed roller worn or chipped.	Replace.
	Feed pawl spring weak or damaged.	Replace.
	Ruptured cartridge case.	Remove ruptured cartridge case.
	Caked carbon in gas cylinder.	Remove carbon.
	Caked carbon in receiver.	Remove carbon.
	Damaged round.	Recharge weapon.
Failure to fire.	Broken or damaged firing pin.	Replace.
	Broken or damaged firing pin spring.	Replace.
	Faulty ammunition.	Remove ammunition.
	Dirty chamber.	Clear and clean or change barrel.
	Weakened or damaged operating rod spring.	Replace.
	Damaged or worn bolt components.	Replace.

Table VII - Troubleshooting guide (continued)

Malfunction	Probable cause	Corrective action
Failure to fire.	Actuator solenoid disconnected or damaged.	Connect or replace.
Failure to unlock.	Operating rod yoke roller fractured or chipped; pin broken.	Replace.
	Burred, bent, or binding operating rod assembly or driving spring guide assembly.	Replace.
Failure to extract.	Damaged or worn bolt components.	Replace.
	Gas cylinder functions improperly.	Replace.
	Burred, bent or binding operating rod assembly or driving spring guide assembly.	Replace.
	Extractor not camming over rim of cartridge case.	Check headspace.
	Broken extractor or spring.	Replace.
	Short recoil.	Clean out gasport with wrench, reamer.
	Gas (floating) piston installed backwards.	Install properly.

Table VII - Troubleshooting guide (continued)

Malfunction	Probable cause	Corrective action
Failure to eject.	Short recoil.	Clean out gasport with wrench, reamer.
	Frozen or damaged ejector or ejector spring.	Clean or replace.
Failure to cock.	Broken sear.	Replace.
	Sear notch worn.	Replace.
	Sear nose worn.	Replace.
	Weak compression helical (sear plunger) spring.	Replace.
	Deformed operating rod sear notch.	Replace.
	Obstruction in receiver.	Clean as required.
	Broken, defective or missing sear plunger or spring.	Replace.
Uncontrolled fire.	Broken or worn sear.	Replace.
	Worn sear notch on operating rod.	Replace.
	Short recoil.	Clean out gasport with wrench, reamer.
Double feeding. (with live round in chamber).	In sequence; A. Failure to fire. B. Failure to extract round. C. Application of incorrect immediate action procedure.	Apply correct immediate action as specified in TM 9-1005-224-12.

USAWECOMDMWI 1005-224

6.9.9 Cleaning after firing. Immediately after firing each weapon should be thoroughly cleaned. All surfaces exposed to powder fouling should be cleaned with steam, rifle bore cleaner, or hot water ($200^{\circ} \pm 10^{\circ}$ F).

Custodian:

U.S. Springfield Armory

Preparing activity:

U.S. Springfield Armory

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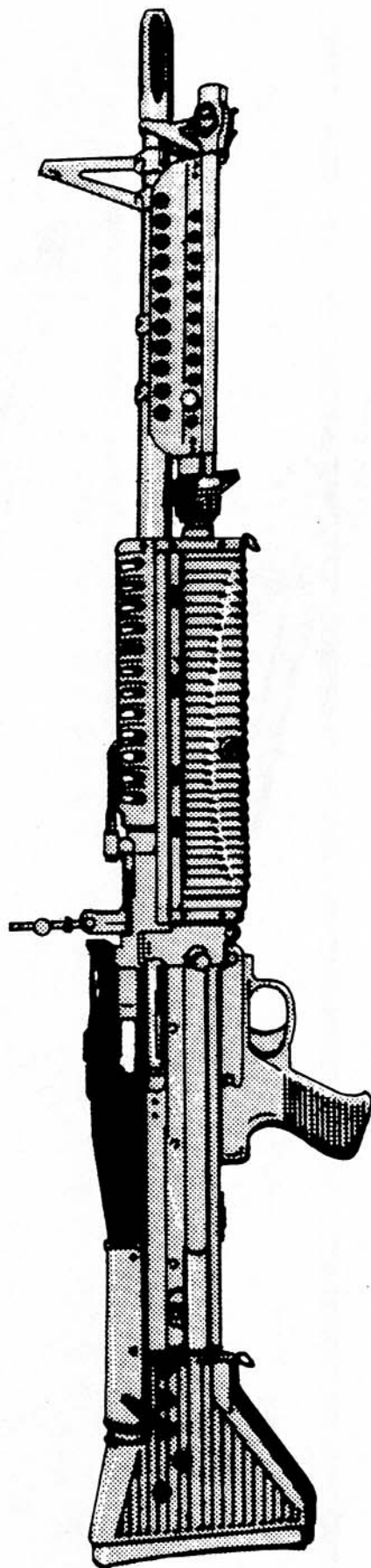
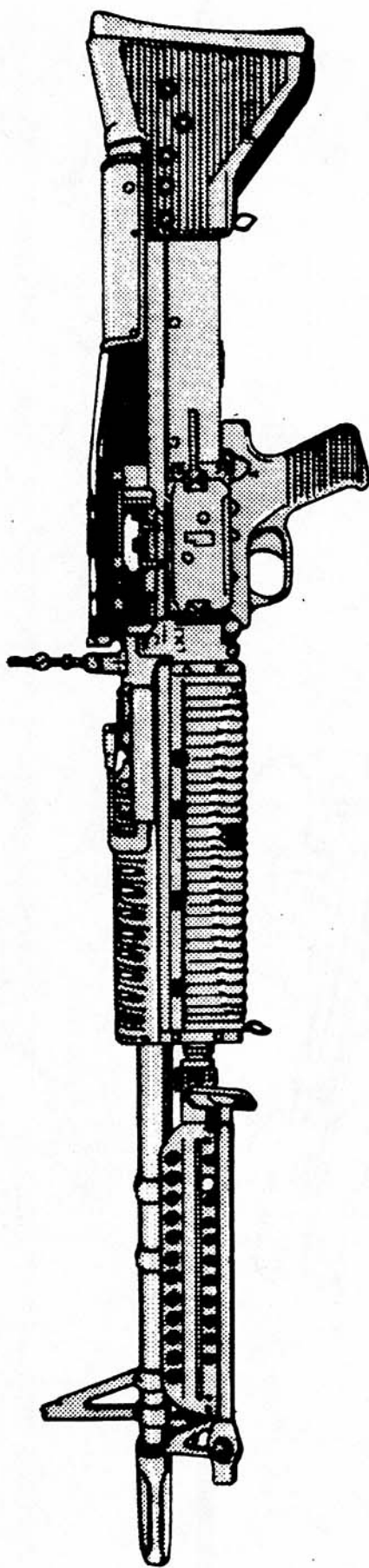
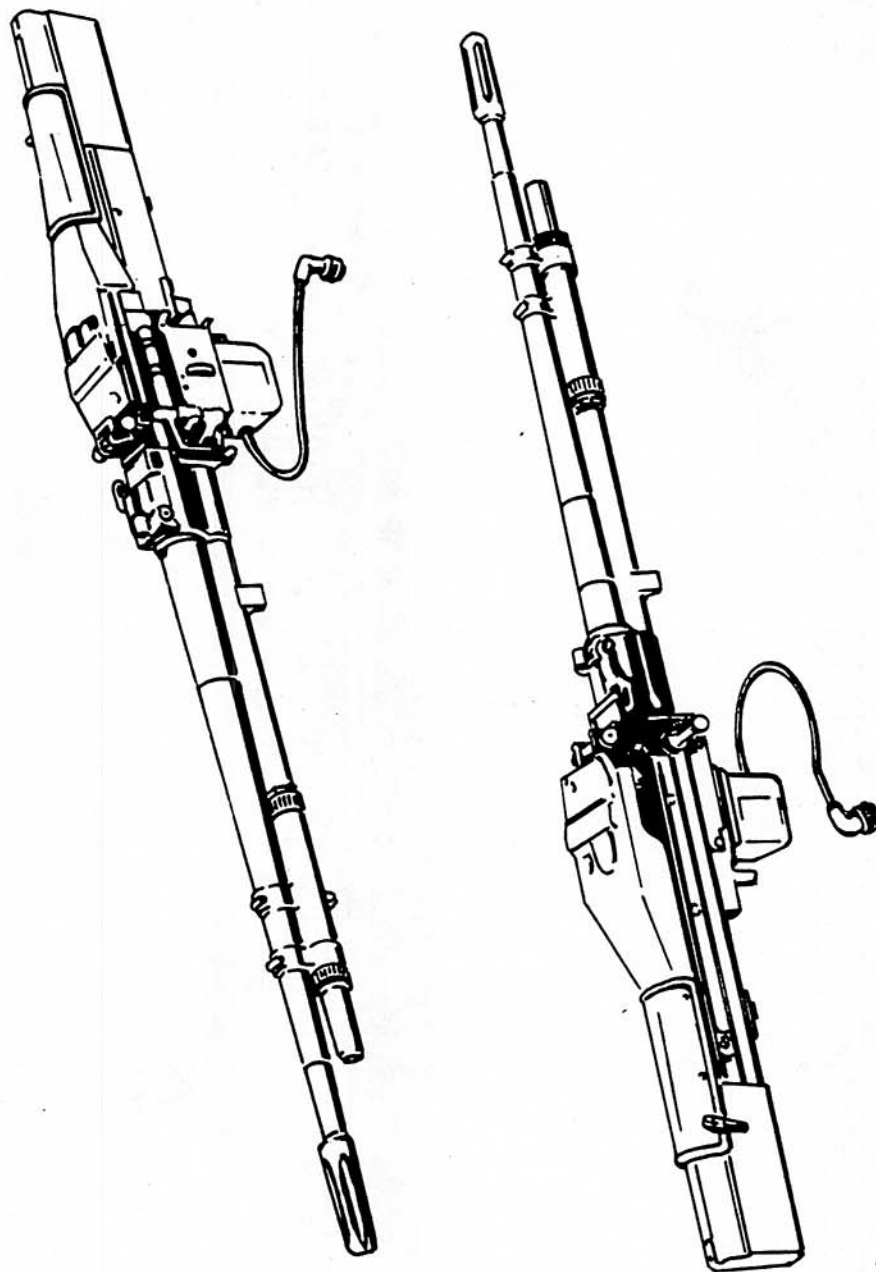


FIGURE 1

GUN, MACHINE, 7.62MM, M60
RIGHT AND LEFT SIDE VIEW

FIGURE 2

GUN, MACHINE 7.62MM M60C
RIGHT AND LEFT SIDE VIEW



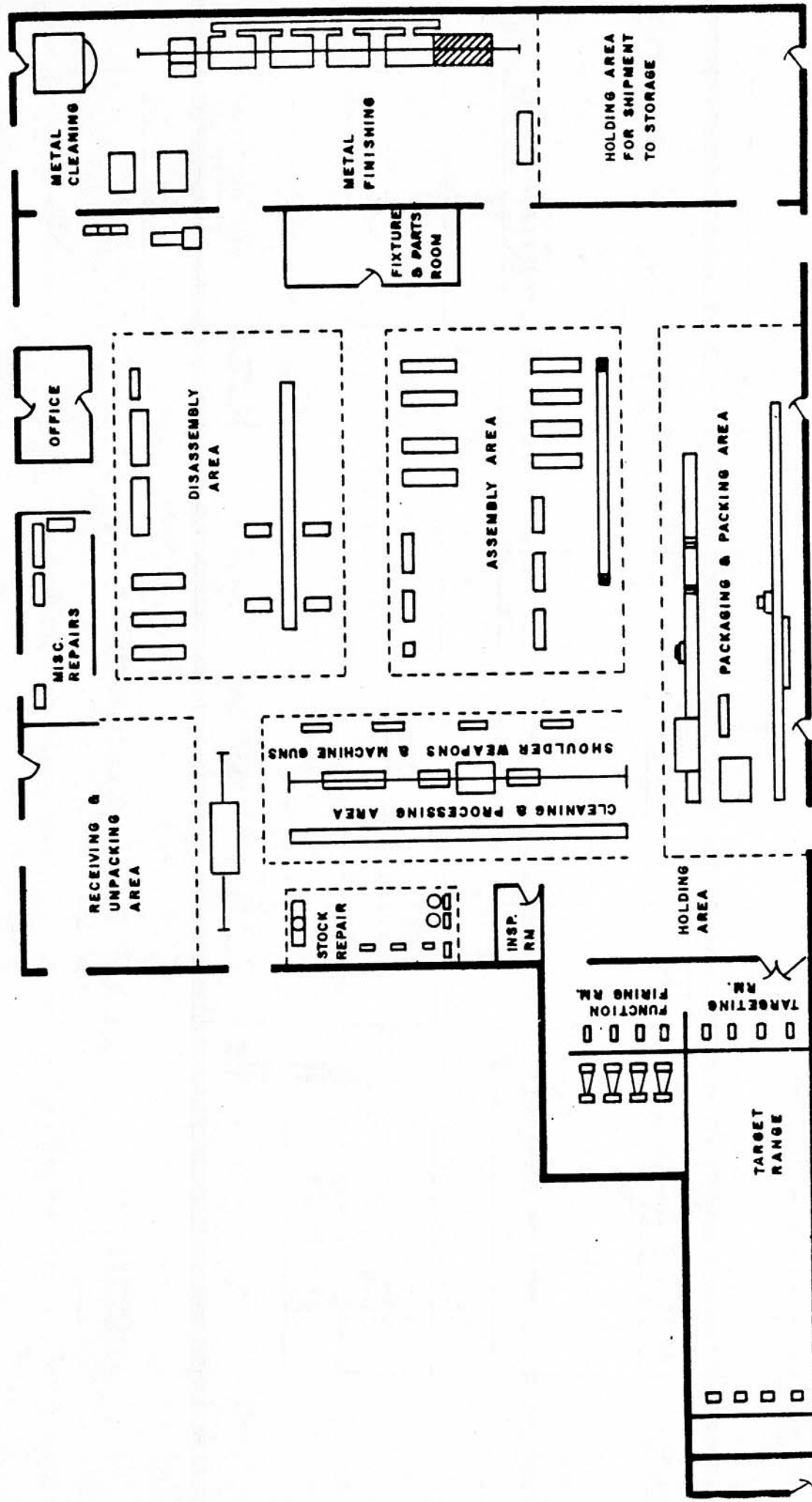
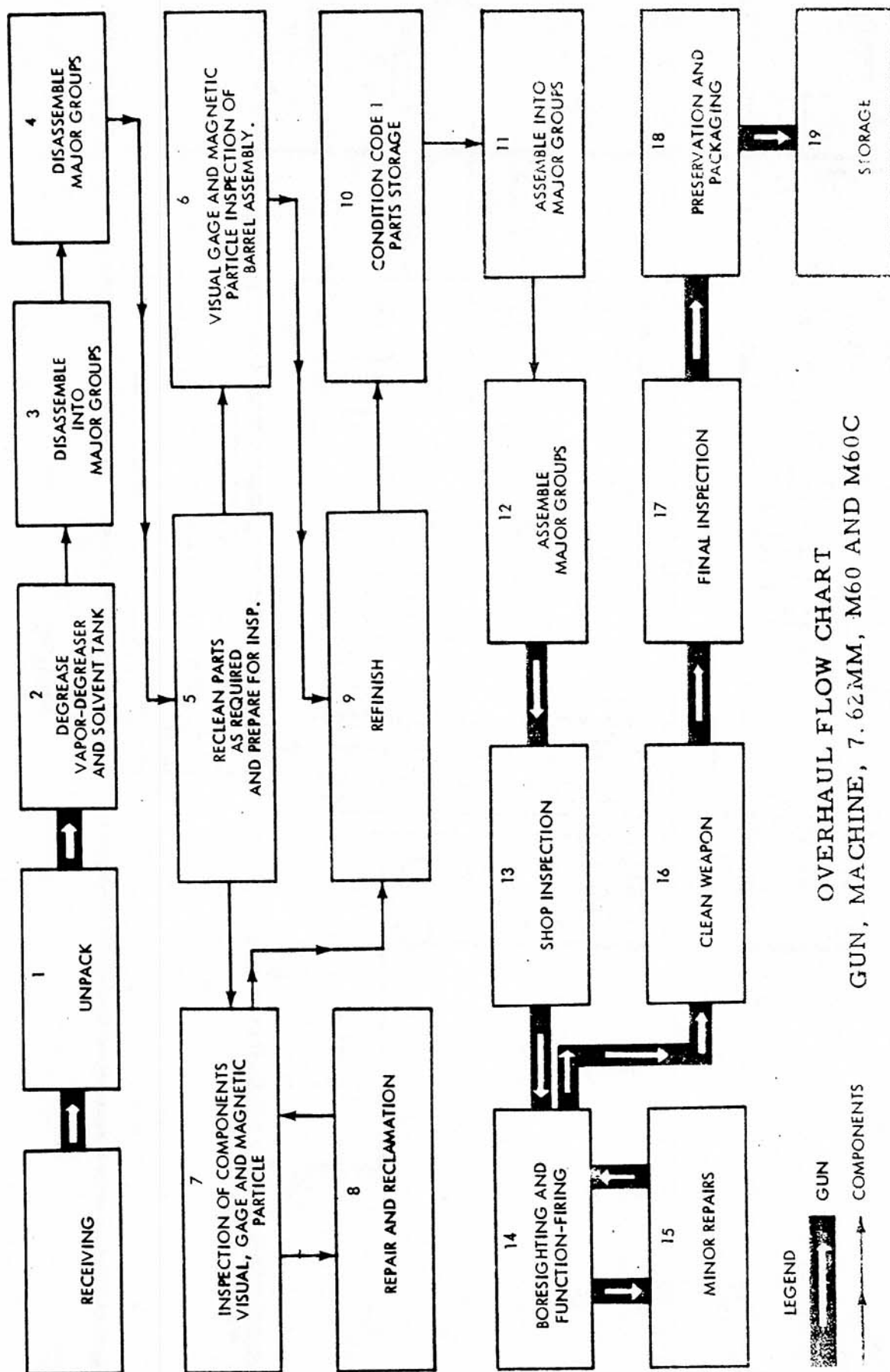
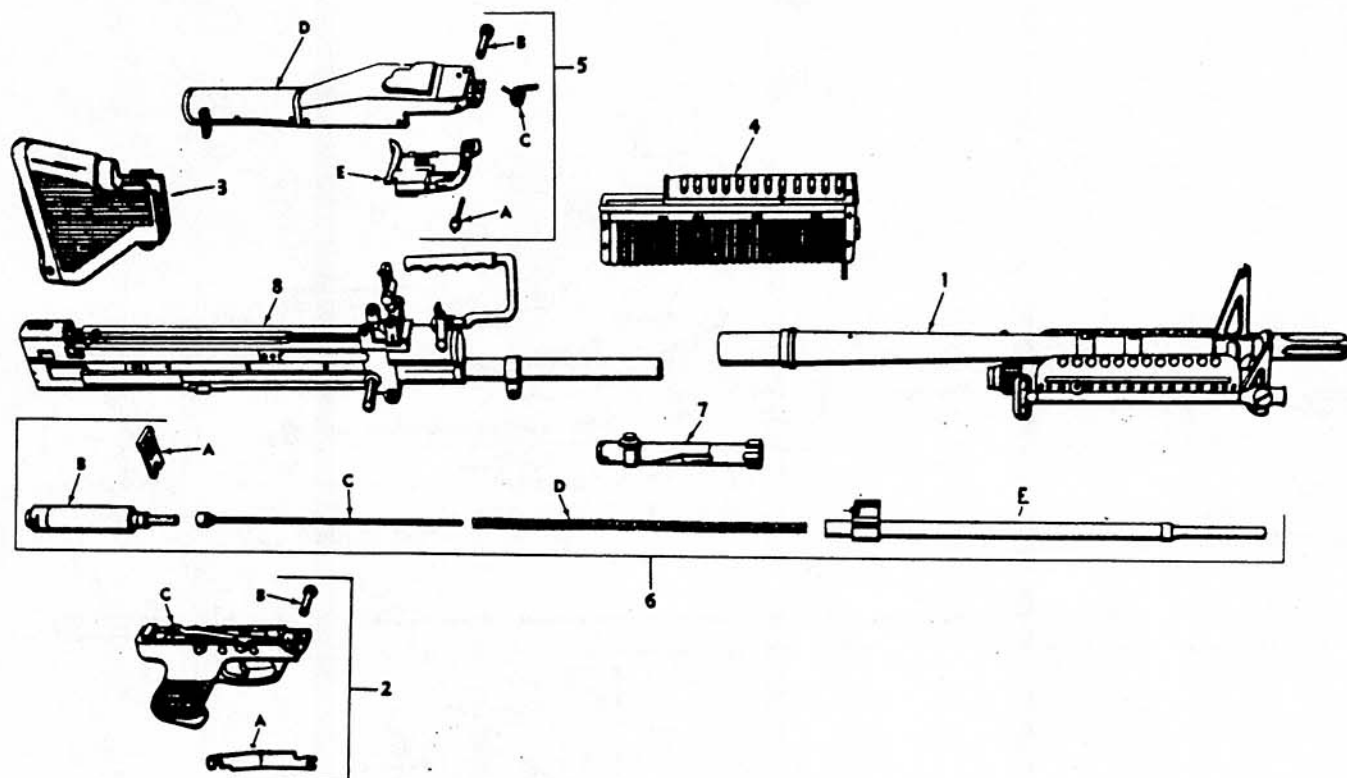


FIGURE 3
SHOP LAYOUT FOR PRODUCTION LINE RECONDITIONING

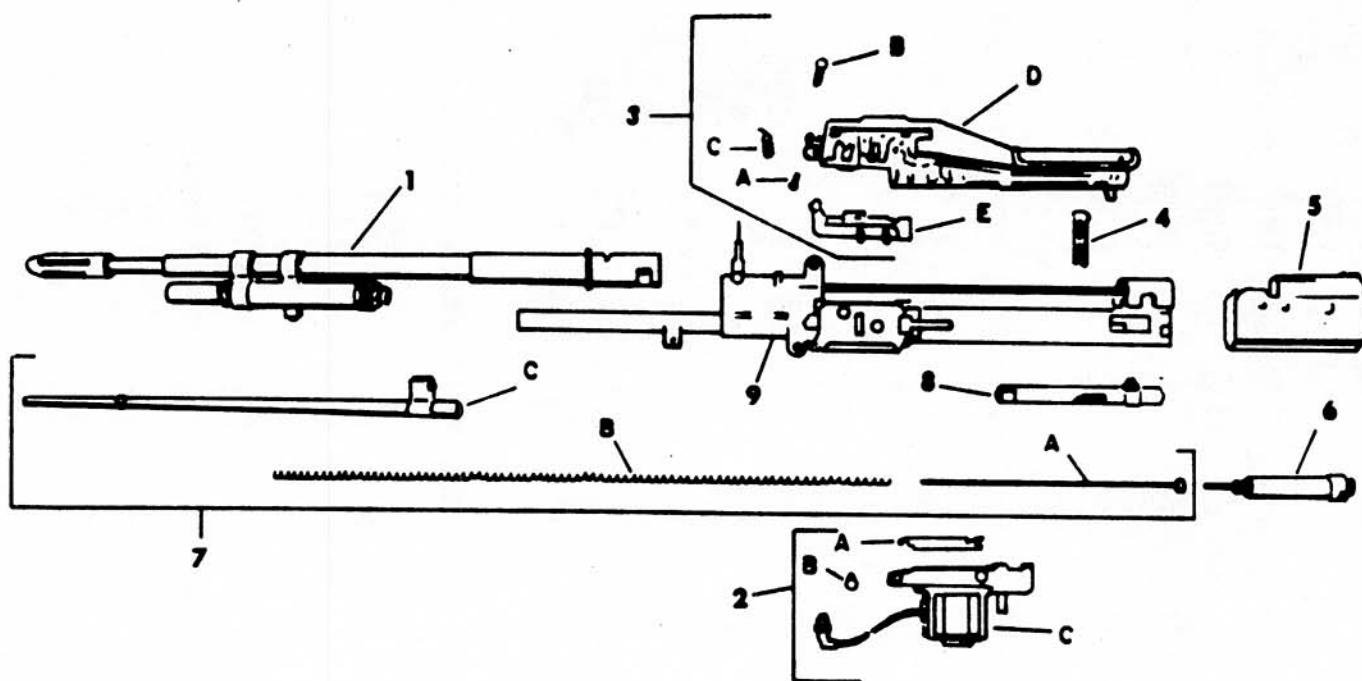




1. Barrel assy with bipod assy	7269027	6. Buffer and operating rod group	
2. Trigger mechanism group		A. Yoke	7269344
A. Spring	7792398	B. Buffer Assy	7269096
B. Pin	7269205	C. Guide Assy	7269199
C. Trigger mechanism grip assy	7269202	D. Spring	7269303
		E. Operating rod assy	7791597
3. Butt stock assy	7269304	7. Bolt Assy	7269064
4. Forearm assy	7269168	8. Receiver Group	
5. Cover assy & tray assy groups			
A. Latch	7269243		
B. Pin	7269247		
C. Spring	7269301		
D. Cover assy	7269114		
E. Tray assy	7792096		

FIGURE 5

MAJOR GROUPS AND ASSEMBLIES



1. Barrel assy	7792083	4. Buffer yoke	7269344
2. Firing actuator group		5. Back plate assy	7792074
A. Spring	7792398	6. Buffer assy	7269096
B. Pin	7269205		
C. Actuator assy	7792089	7. Operating rod group	
3. Cover assy & tray assy groups		A. Guide assembly	7269199
A. Latch	7269243	B. Spring	7269303
B. Pin	7269247	C. Operating rod assy	7791597
C. Spring	7269301	8. Bolt assy	7269064
D. Cover assy	7269114	9. Receiver group	
E. Tray assy	7792096		

FIGURE 6

MAJOR GROUPS AND ASSEMBLIES M60C

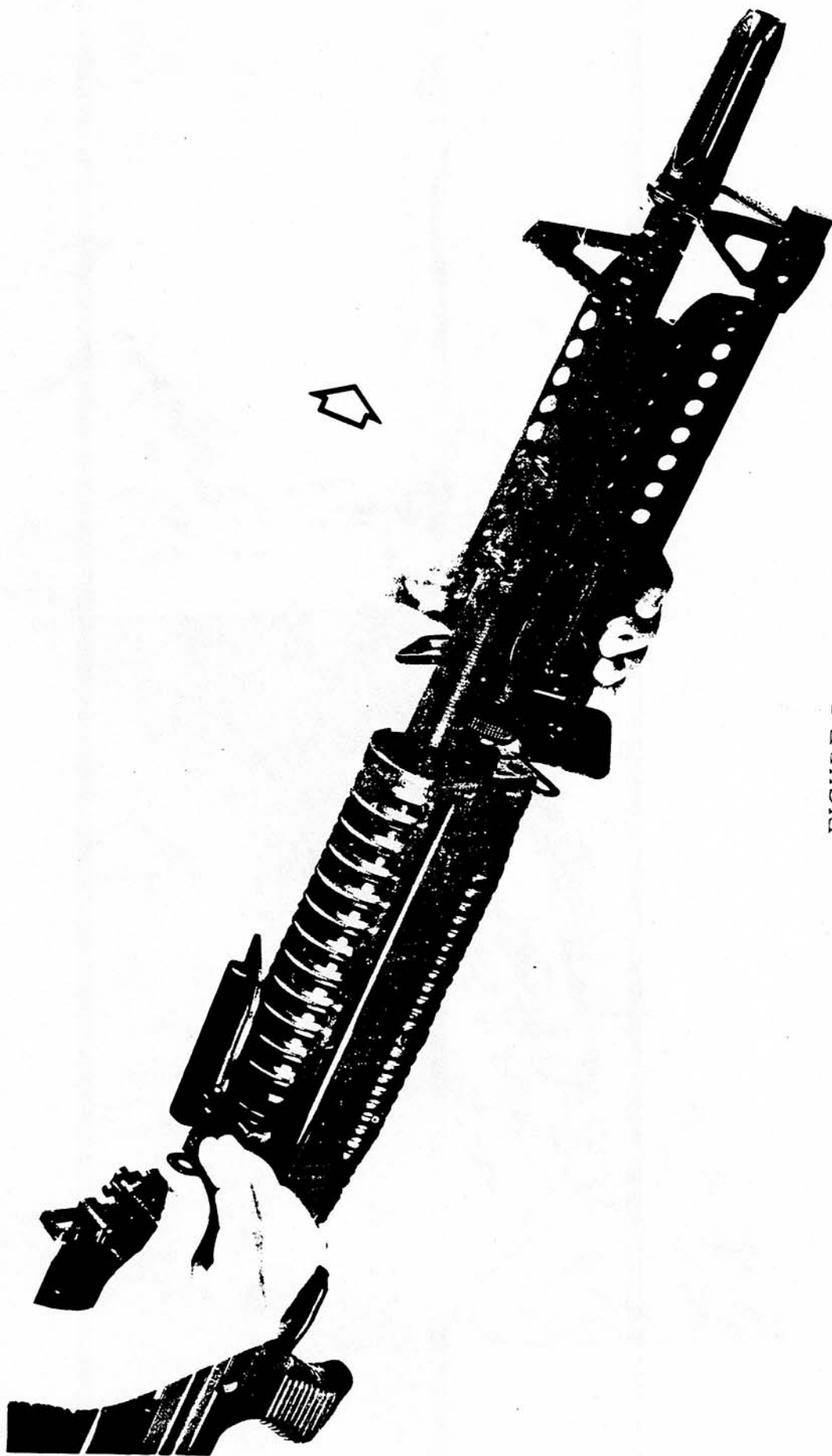


FIGURE 7

REMOVAL OF BARREL ASSEMBLY M60

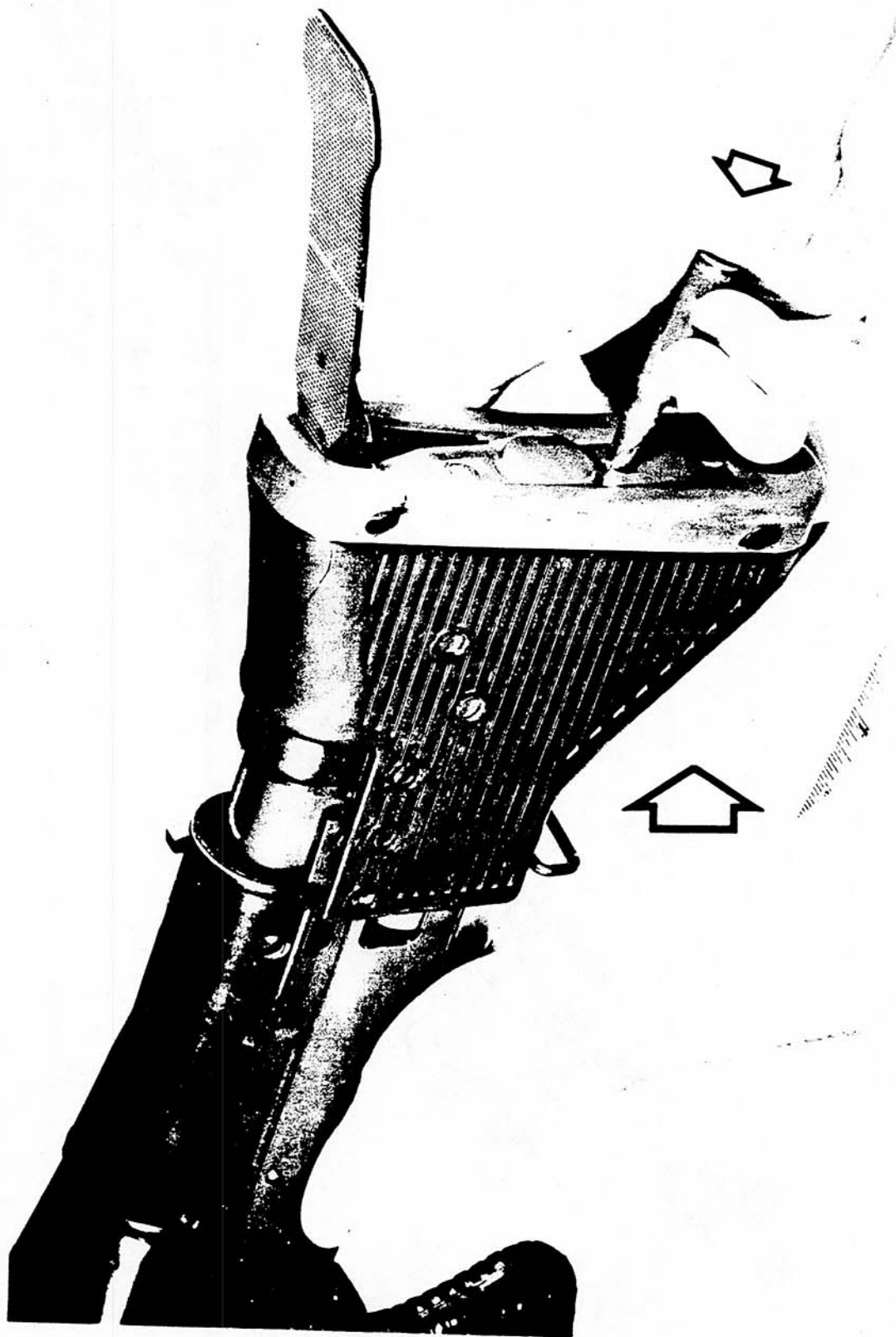


FIGURE 8

REMOVAL OF BUTTSTOCK M60

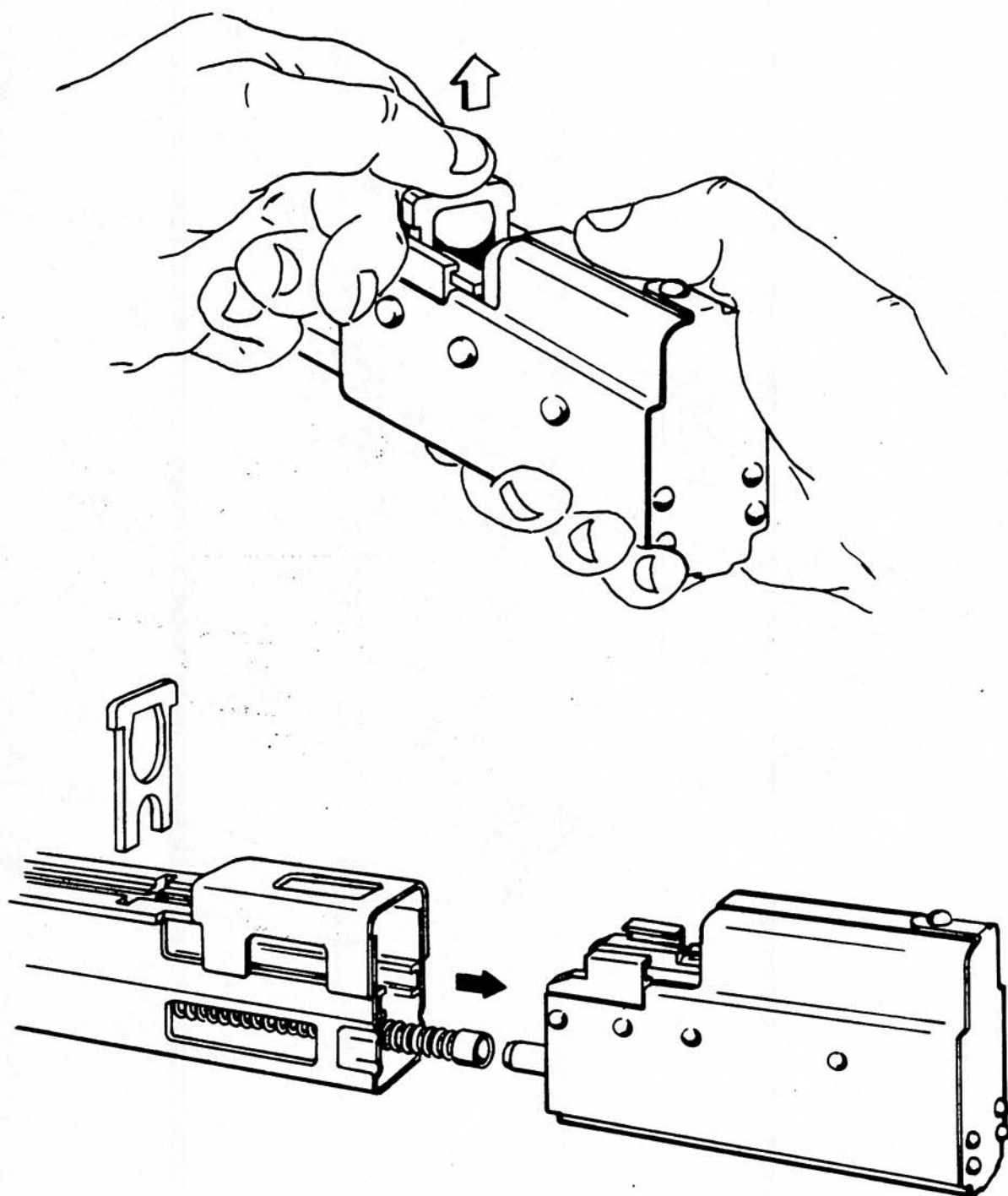


FIGURE 9

REMOVAL OF BACKPLATE M60C

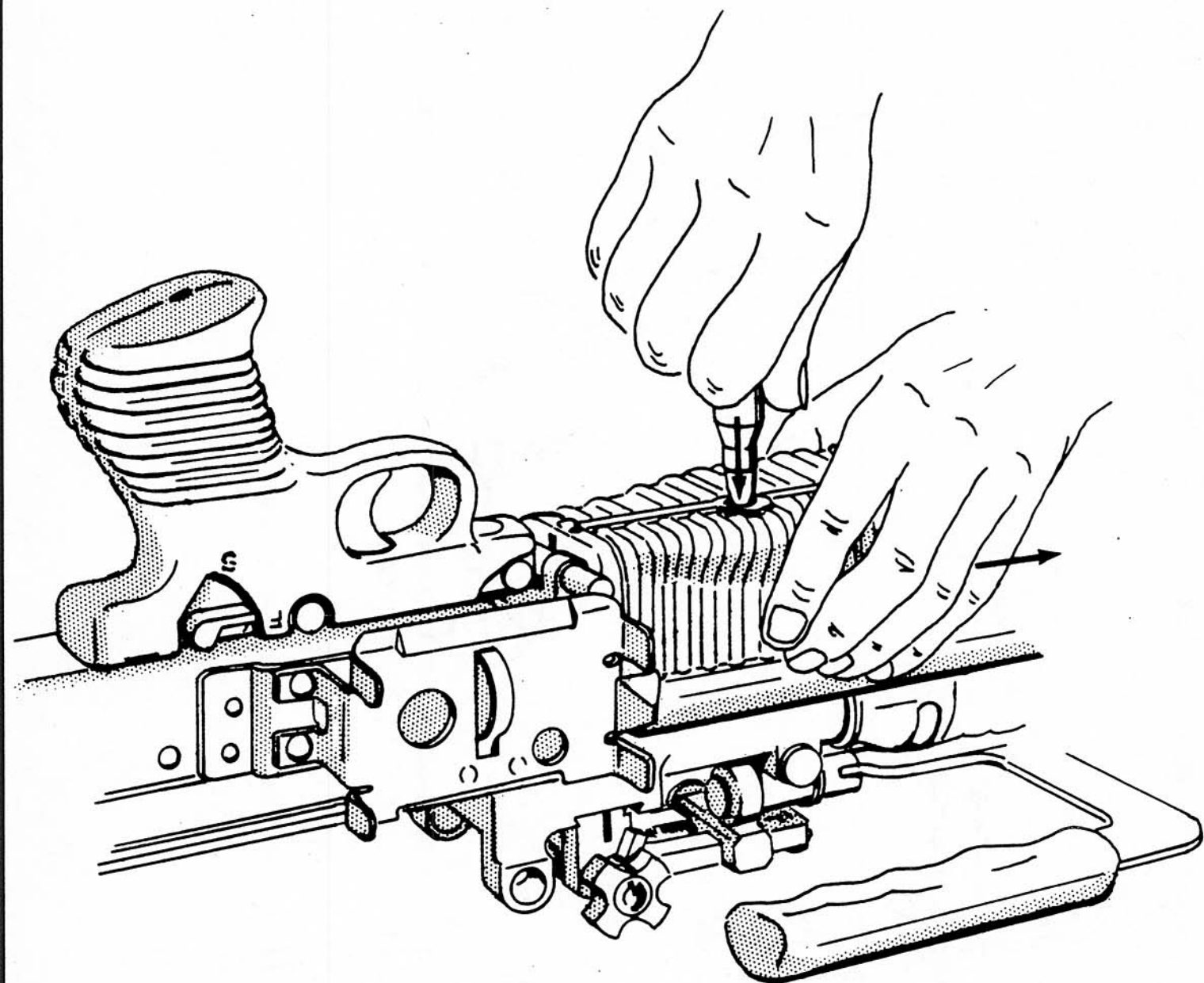


FIGURE 10

REMOVAL OF FOREARM ASSEMBLY

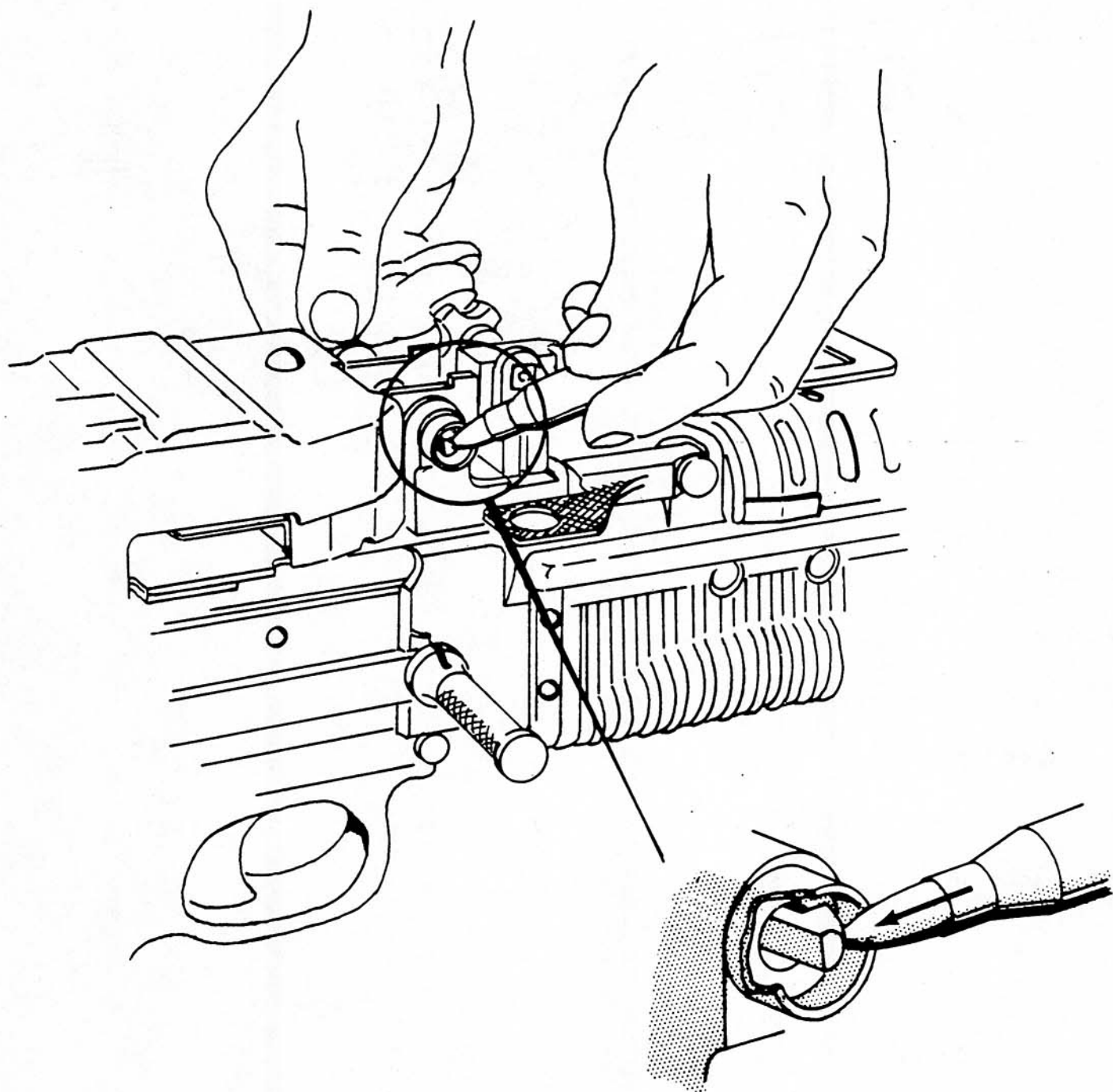
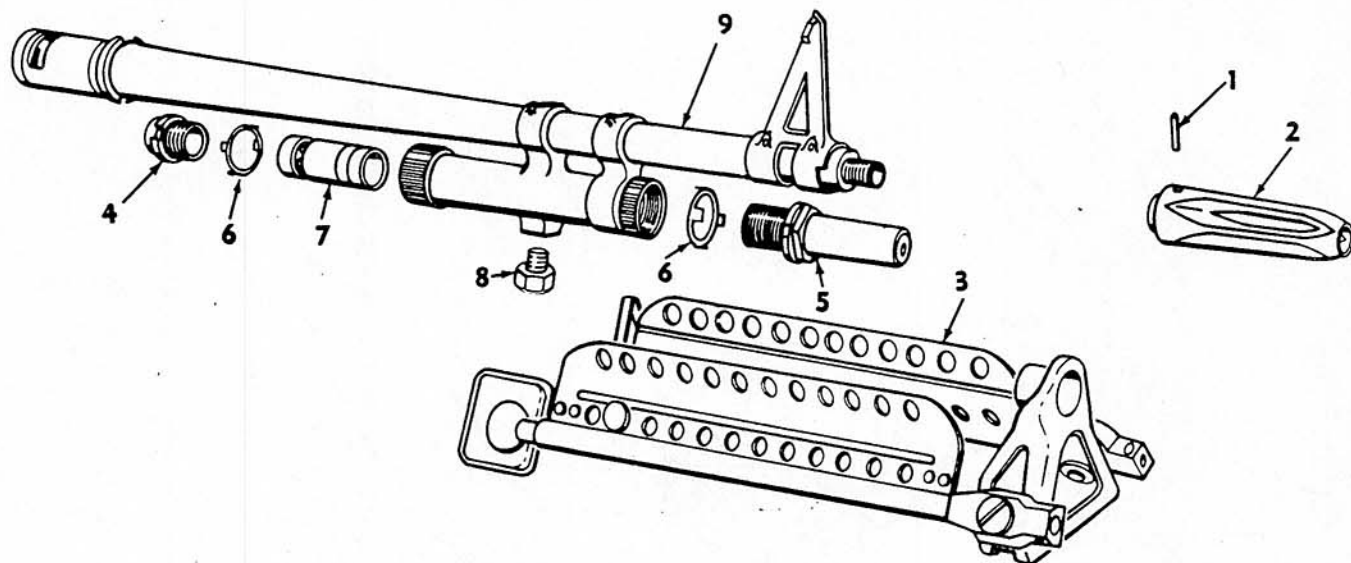


FIGURE 11

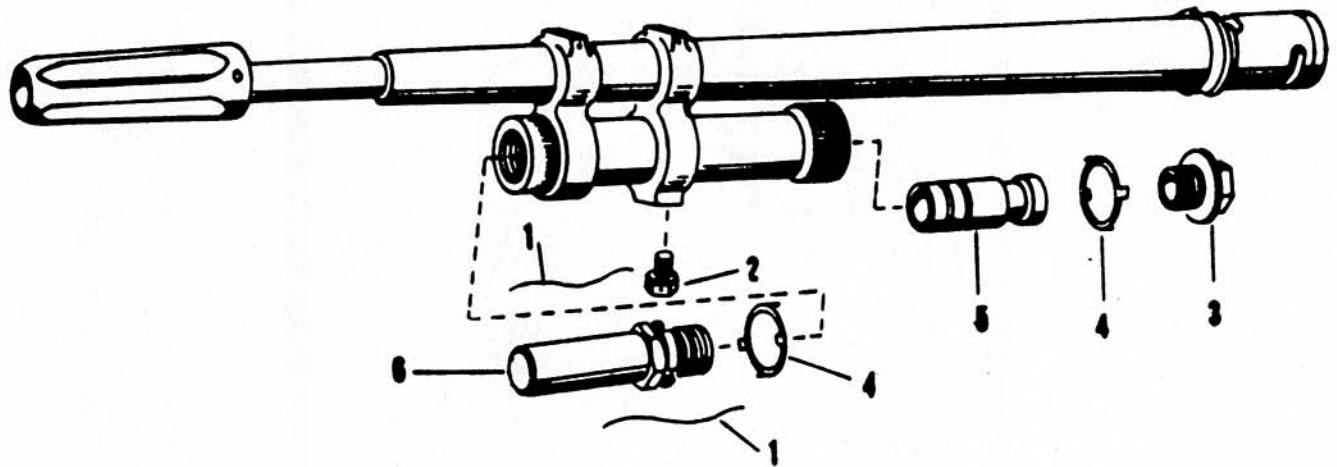
REMOVAL OF COVER ASSEMBLY, M60



1. Pin	MS39086-141	6. Washer	7269035
2. Flash Suppressor	7269034	7. Piston	7791247
3. Bipod Assy	7793009	8. Plug	7792093
4. Nut	7269031	9. Barrel assv	7269028
5. Extension	7269030		

FIGURE 12

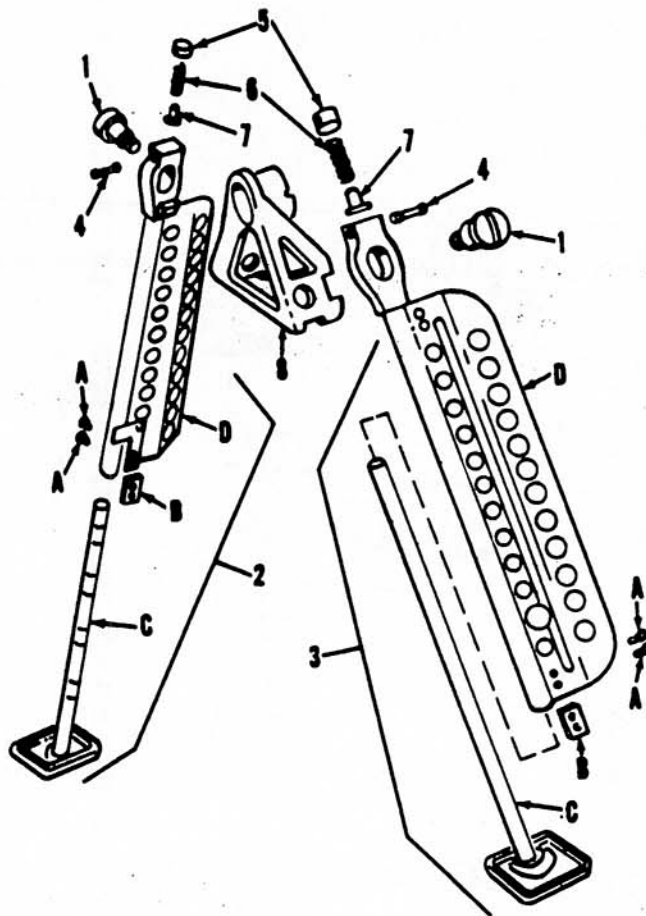
BARREL ASSEMBLY WITH BIPOD ASSEMBLY M60



1. Wire	MS20995-C32	4. Washer	7269035
2. Plug	7792093	5. Piston	7791247
3. Nut	7269031	6. Extension	7269030

FIGURE 13

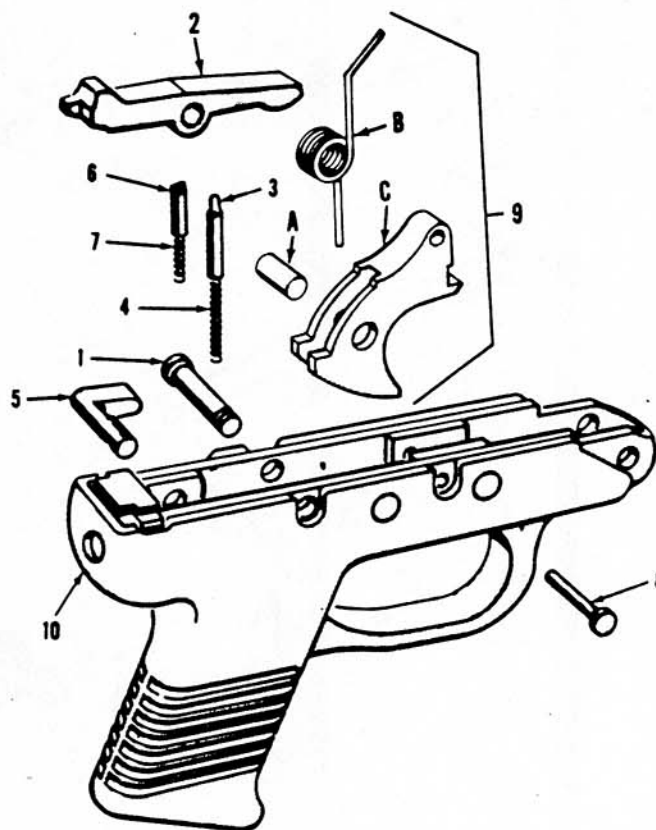
BARREL ASSEMBLY M60C



1. Screw	7269051	4. Pin	7269048
2. Right hand leg assy	7269047	5. Retainer	7269053
A. Rivet	7269058	6. Spring	7269052
B. Key	7269057	7. Plunger	7269050
C. Foot Assy	7269061	8. Pivot assy	7793010
D. Housing Assy	7269062		
3. Left hand leg assy	7269046		
A. Rivet	7269058		
B. Key	7269057		
C. Foot Assy	7269055		
D. Housing Assy	7269056		

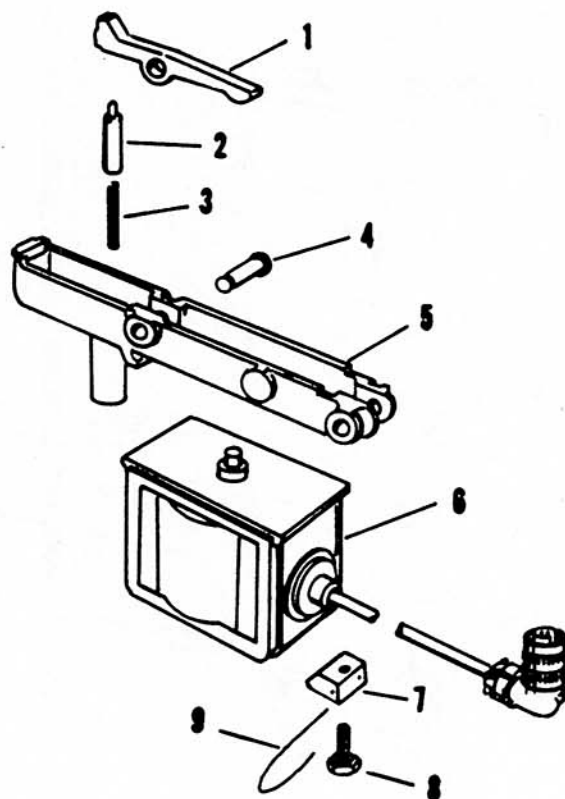
FIGURE 14

BIPOD ASSEMBLY M60



1. Pin	7269205	7. Spring	7269210
2. Sear	7269209	8. Pin	7267204
3. Plunger	7269207	9. Trigger Assy	7269212
4. Spring	7269211	A. Pin	7269229
5. Safety	7269415	B. Spring	7269230
6. Plunger	7269206	C. Trigger	7269228
		10. Housing Assy	7269203

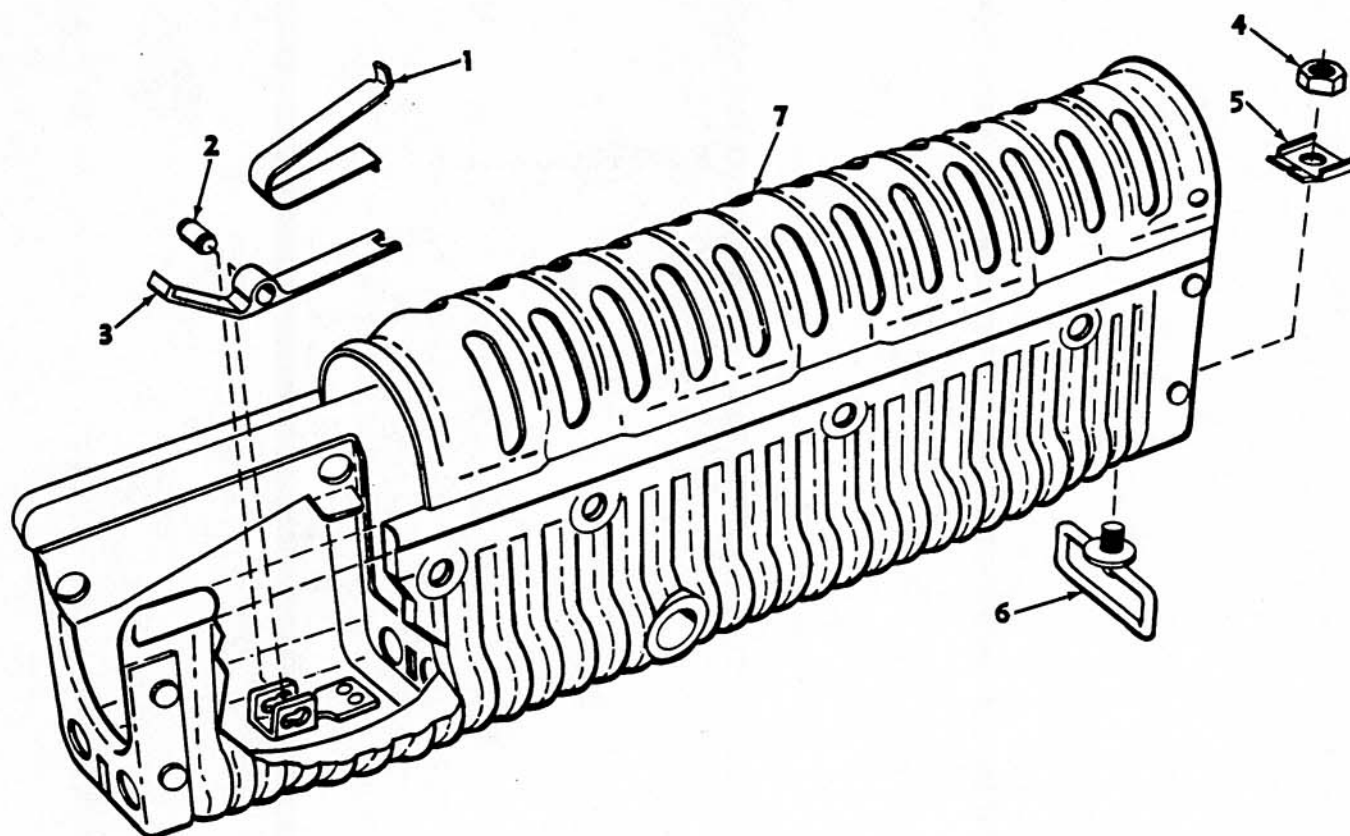
FIGURE 15.



1. Sear	7269209	6. Solenoid	7792385
2. Plunger	7269207	7. Flange	7792092
3. Spring	7269211	8. Bolt	7792095
4. Pin	7269205	9. Wire	MS20995-C32
5. Housing			

FIGURE 16

FIRING ACTUATOR ASSEMBLY M60C



- | | |
|-----------|-------------|
| 1. Spring | 7269187 |
| 2. Pin | 7269184 |
| 3. Catch | 7269180 |
| 4. Nut | MS35650-103 |

- | | |
|-----------|---------|
| 5. Washer | 7269189 |
| 6. Swivel | 7269188 |
| 7. Cover | 7269183 |

FIGURE 17

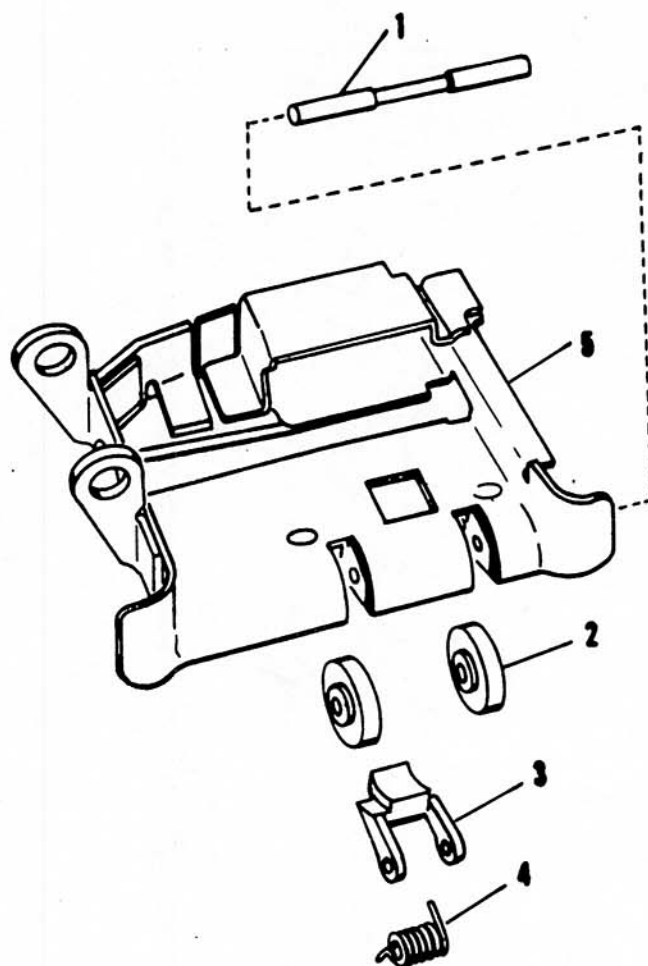
FOREARM ASSEMBLY M60

LEGEND FOR FIGURE 18

1. Feed Cam Assembly	7269115
A. Retainer	7269124
B. Plunger	7269123
C. Spring	7269125
D. Channel	11010292
2. Lever Assembly	7269119
A. Clip	7269146
B. Feed Lever	7269145
3. Cotter Pin	11010181
4. Shaft	11010152
5. Front Cartridge Guide	7269116
6. Rear Cartridge Guide	7269117
7. Pawl Assembly	7269120
A. Shaft	7269151
B. Pawl	7269150
C. Spring	7269152
D. Chassis	7269149
8. Housing Assembly	7269118
A. Lever	7269137
B. Latch	7269136
C. Spring	7791271
D. Pin	7791270
E. Rivet	7269139
F. Bumper Assembly	7269126
G. Rivet	7269112
H. Pad Assembly	7269138
J. Shield	7269140
K. Pin	7269143
L. Spring	7269141
M. Washer	7269144
N. Frame Assembly	7269128



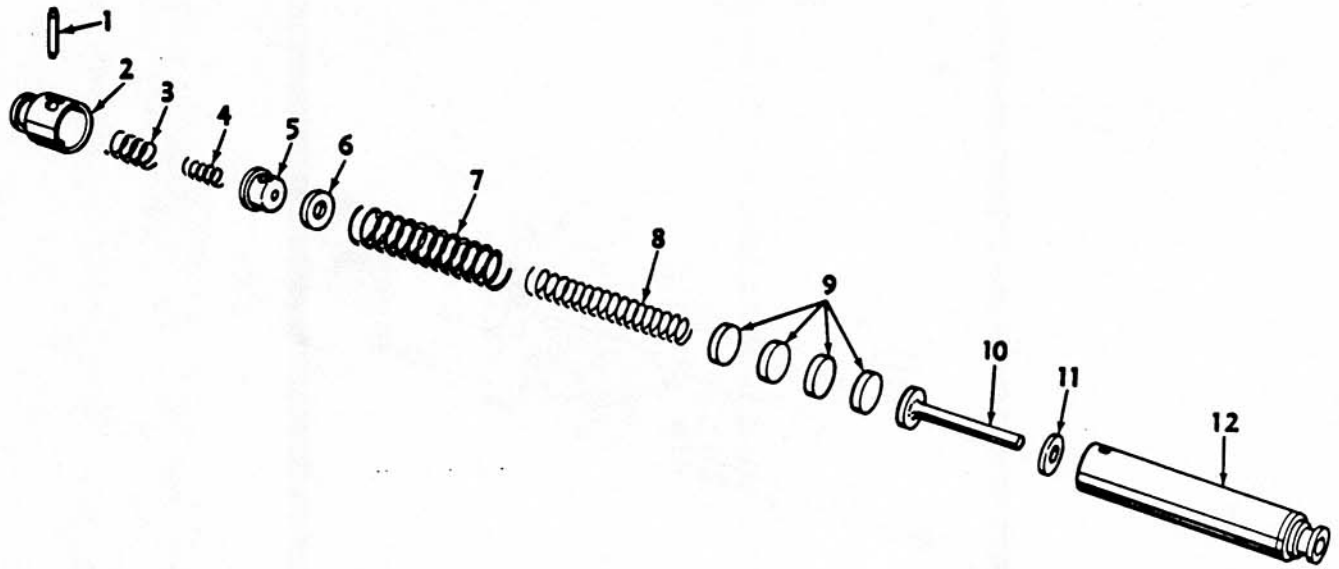
FIGURE 18



1. Shaft	7790724	4. Spring	7269335
2. Roller	7269333	5. Frame	7792097
3. Pawl	7269332		

FIGURE 19

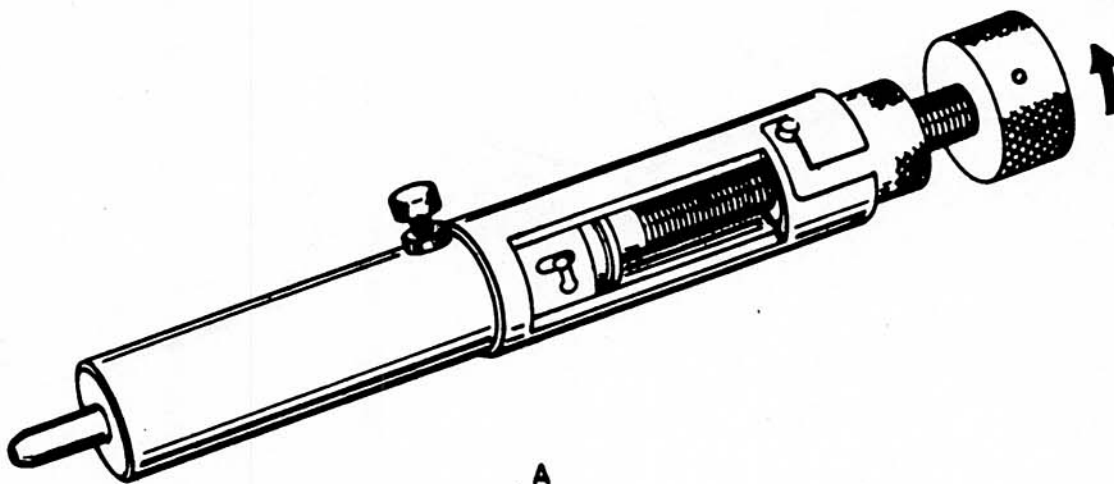
FEED TRAY ASSEMBLY M60 AND M60C



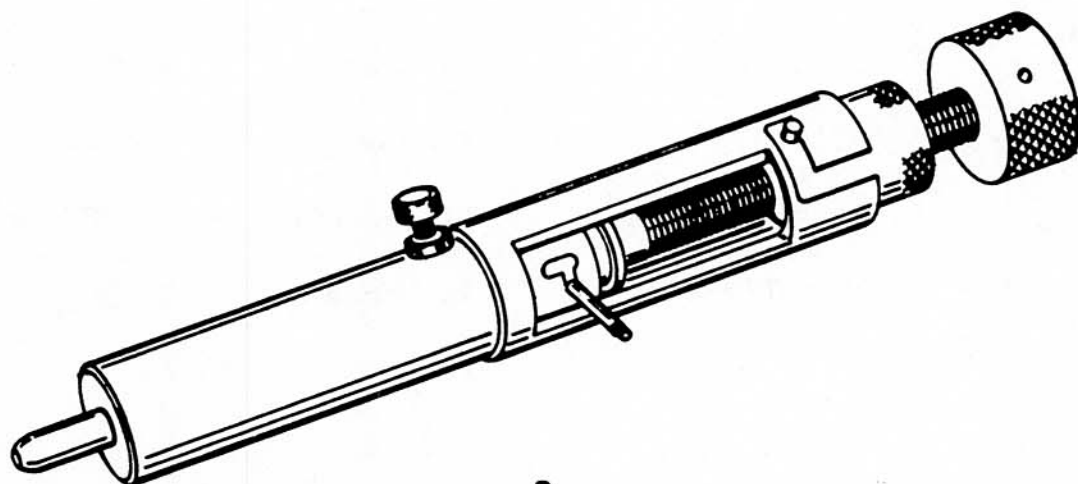
1. Pin	7269101	7. Spring	7269106
2. Cover	7269098	8. Spring	7269105
3. Spring	7269108	9. Pad	7269102
4. Spring	7269107	10. Plunger	7269103
5. Cap	7269097	11. Packing	AN6227-B6
6. Packing	MS28775-017	12. Housing	7269099

FIGURE 20

BUFFER ASSEMBLY M60 AND M60C



A



B

FIGURE 21

AUXILIARY BUFFER ASSEMBLY - DISASSEMBLY FIXTURE
M60 AND M60C

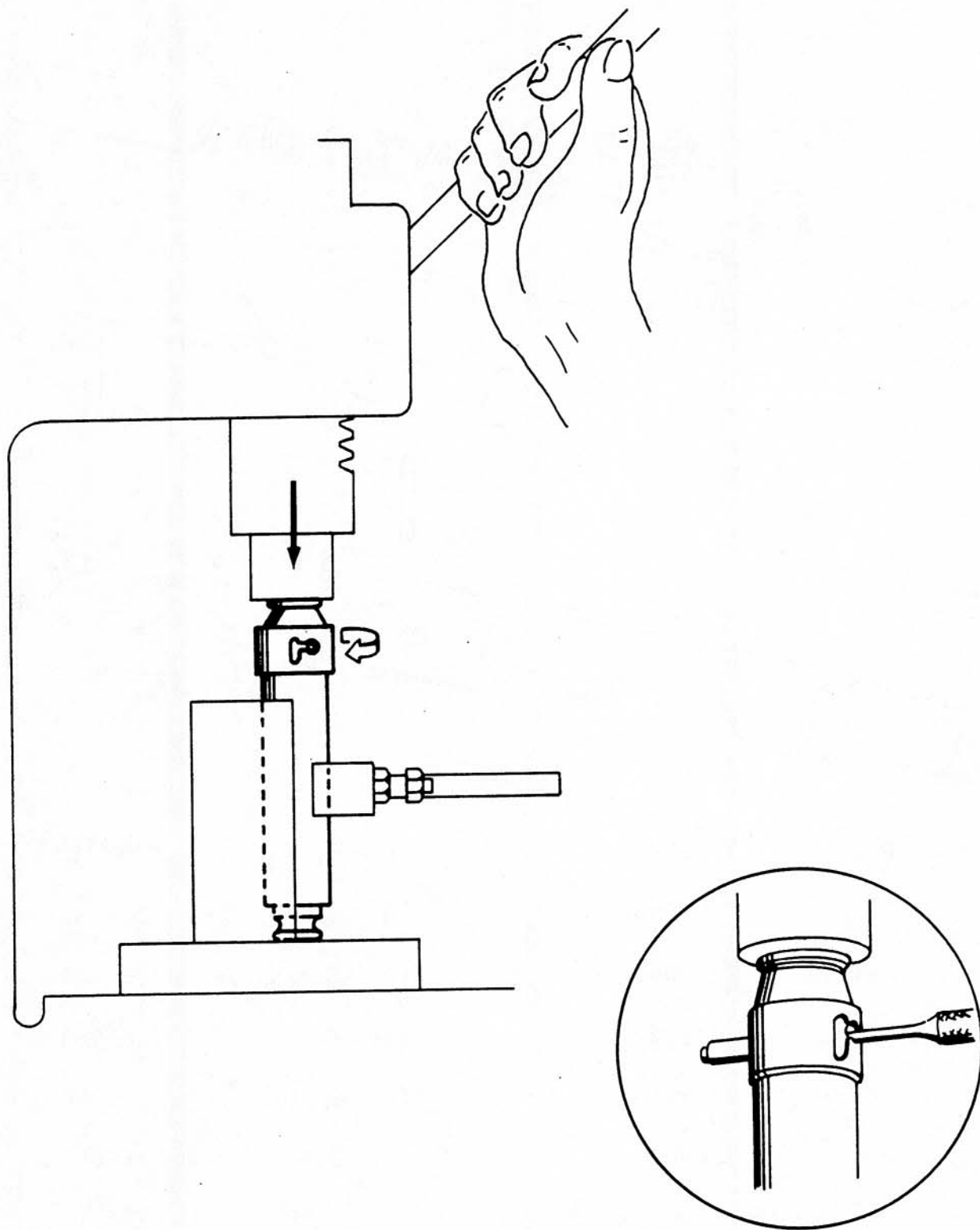
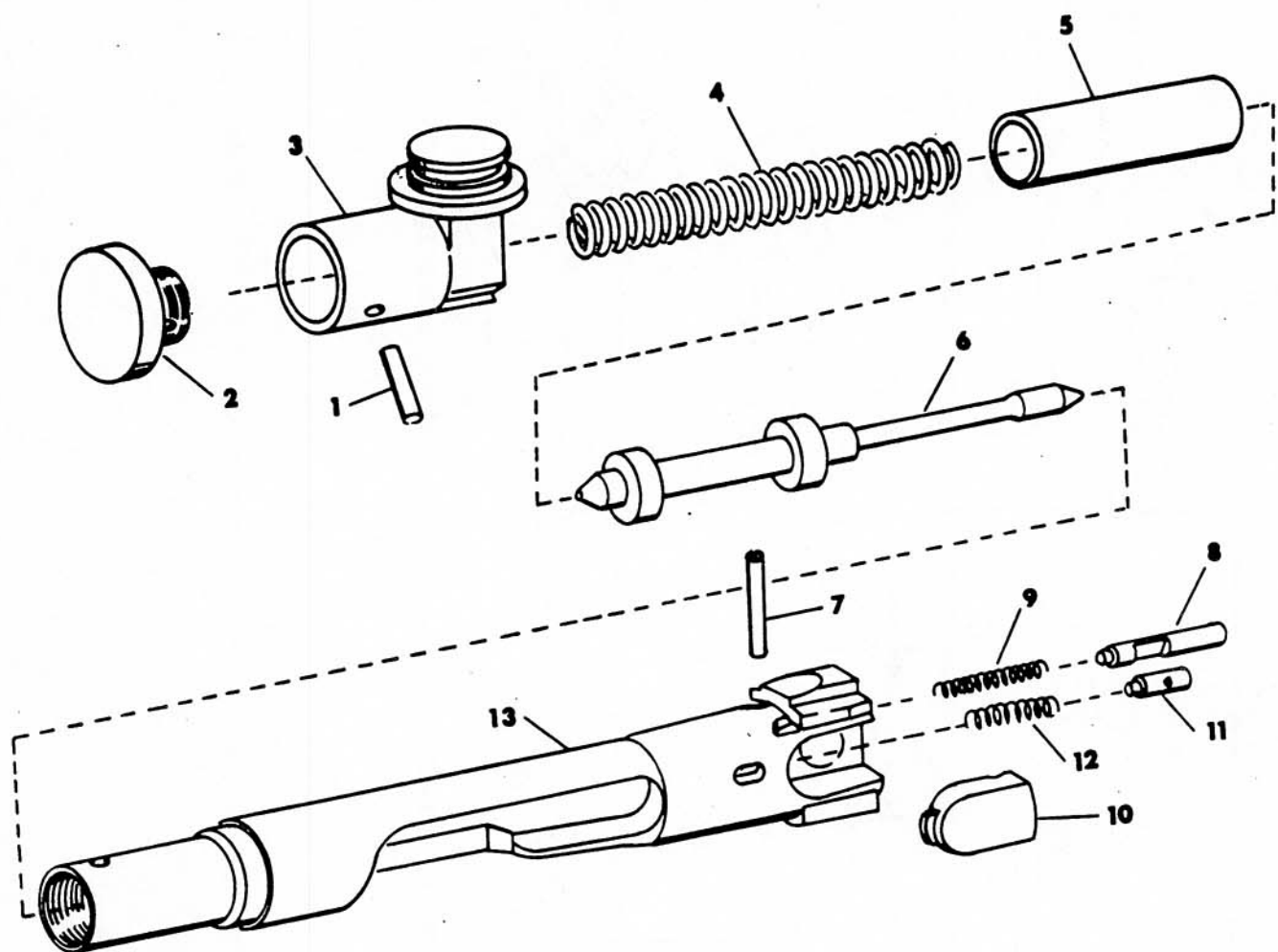


FIGURE 22

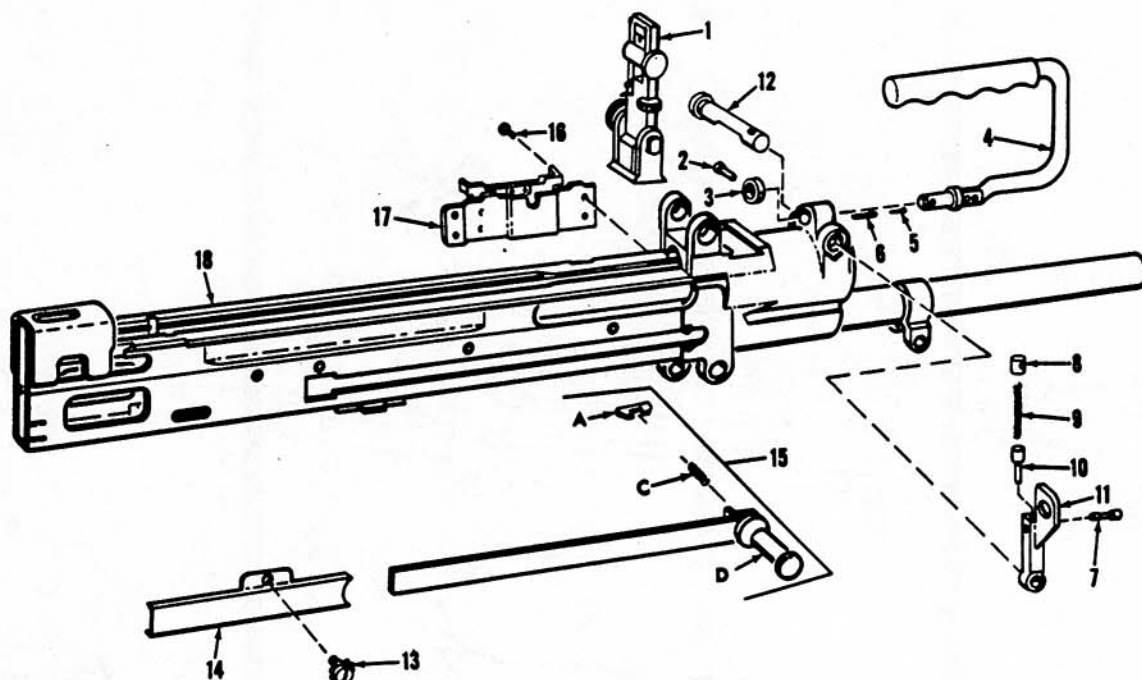
BUFFER ASSEMBLY - DISASSEMBLY FIXTURE



1. Pin	7792920	8. Ejector	11010375
2. Plug	7791600	9. Spring	7269085
3. Actuator	7269063	10. Extractor	7790907
4. Spring	7269087	11. Plunger	7269083
5. Bearing	7269065	12. Spring	7269086
6. Pin	7269081	13. Bolt	7269060
7. Pin, spring	MS39086-81		

FIGURE 23

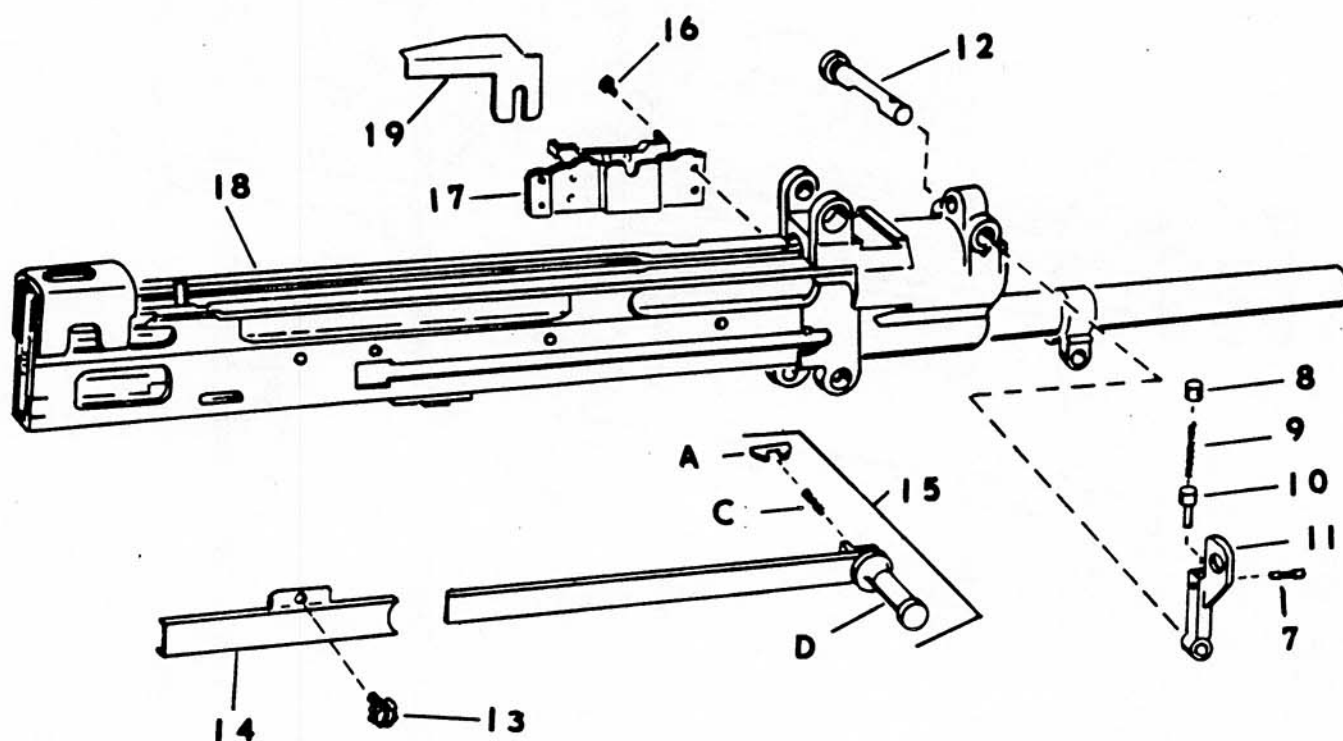
BOLT ASSEMBLY M60 AND M60C



1. Sight Assy	7791437	12. Shaft	7269276
2. Pin	7269246	13. Screw	7790559
3. Ring	7269267	14. Guide	11010155
4. Handle	7269231	15. Handle Assy	7791621
5. Plunger	7269250	A. Retainer	7269237
6. Spring	7269302	C. Spring	7791522
7. Pin	7269248	D. Slide	7269239
8. Retainer	7269266	16. Rivet	432762
9. Spring	7269300	17. Bracket Group	
10. Plunger	7269249	18. Receiver	7269251
11. Lever	7269244		

FIGURE 24

RECEIVER GROUP M60

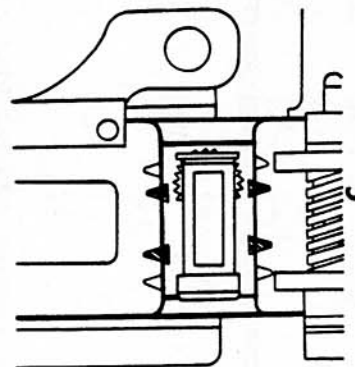


7. Pin	7269248	14. Guide	11010155
8. Retainer	7269266	15. Handle Assembly	7791621
9. Spring	7269300	(A) Retainer	7269237
10. Plunger	7269249	(C) Spring	7791522
11. Lever	7269244	(D) Slide	7269239
12. Shaft	7269276	16. Rivet	432762
13. Screw	7790559	17. Bracket Group	
		18. Receiver	7269251
		19. Deflector	7792531

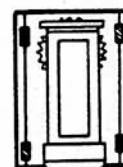
FIGURE 25

RECEIVER GROUP M60C

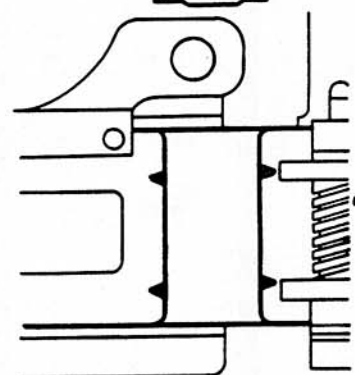
Rear Sight
In Receiver



Rear Sight
Removed from Receiver



Remove Bur From
Stake Marks Before
Re-Installing



Rear Sight Installed
And Restaked After
Completion of Targeting
And Accuracy Test
(See 4.5.5.4)

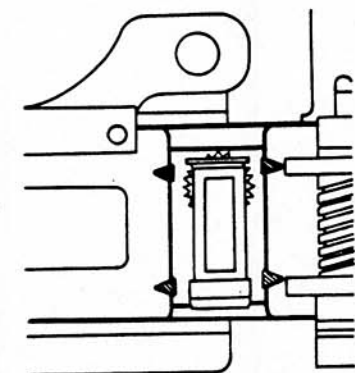
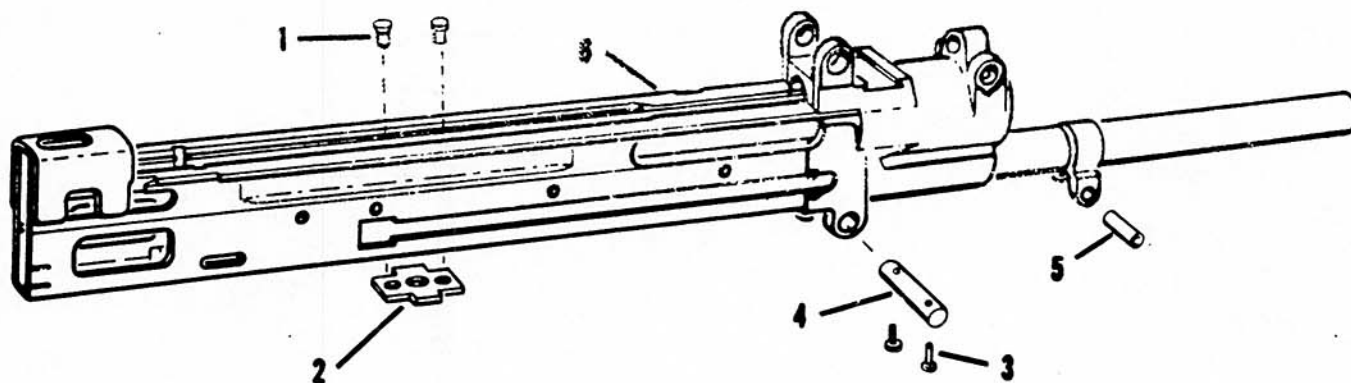


FIGURE 26

REMOVAL AND INSTALLING REAR SIGHT M60

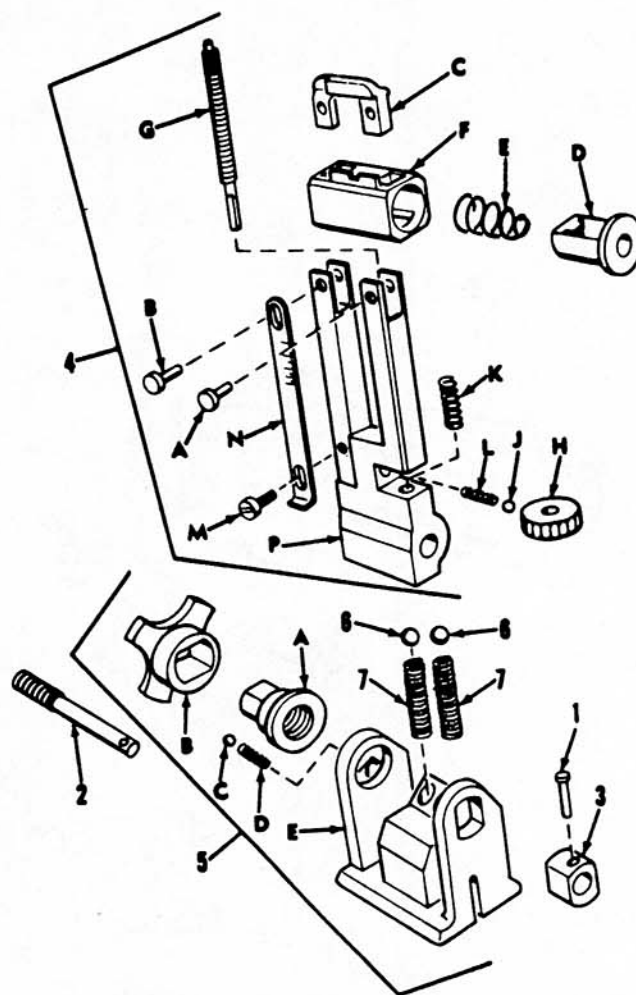


1. Rivet	7792972
2. Plate	7792974
3. Pin	7792971

4. Pin	7792975
5. Pin	7792976
6. Receiver Assy	7269251

FIGURE 27

RECEIVER ASSEMBLY M60 AND M60C
(PARTIALLY EXPLODED VIEW)



Rear Sight Assy

1. Rivet	7269280
2. Screw	7269281
3. Slide	7269282
4. Leaf Assy	7269279

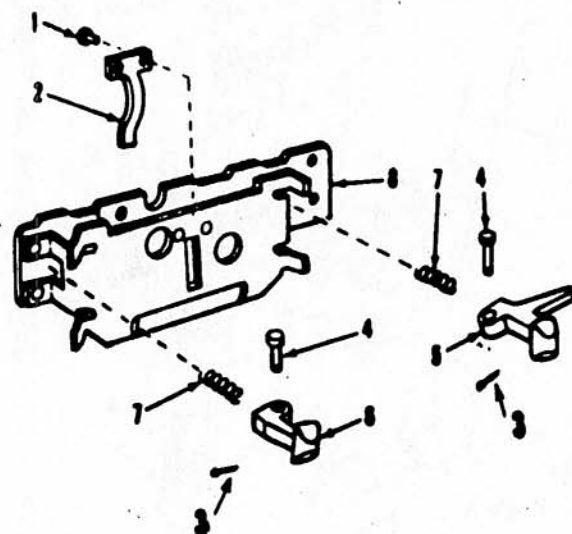
A. Rivet	7269294
B. Rivet	7269293
C. Cap	7269288
D. Release Assy	7269292
E. Spring	7269299
F. Slide	7269289
G. Screw	7269295
H. Knob	7269291

J. Ball	MS19061-3
K. Spring	7269298
L. Spring	7269287
M. Screw	7269296
N. Scale	7791409
P. Leaf	7269290

5. Base & Lateral Knob Assy	7269278
-----------------------------	---------

A. Sleeve	7269286
B. Knob	7269285
C. Ball	MS19061-3
D. Spring	7269287
E. Base	7269284
6. Ball	MS19061-5
7. Spring	7269283

FIGURE 28
REAR SIGHT ASSEMBLY M60



1. Rivet	7790556	5. Latch	7790554
2. Spring	7790549	6. Latch	7790553
3. Cotter Pin	MS24665-18	7. Spring	7790551
4. Pin	7792069	8. Bracket	7790550

FIGURE 29

MAGAZINE BRACKET GROUP M60 AND M60C

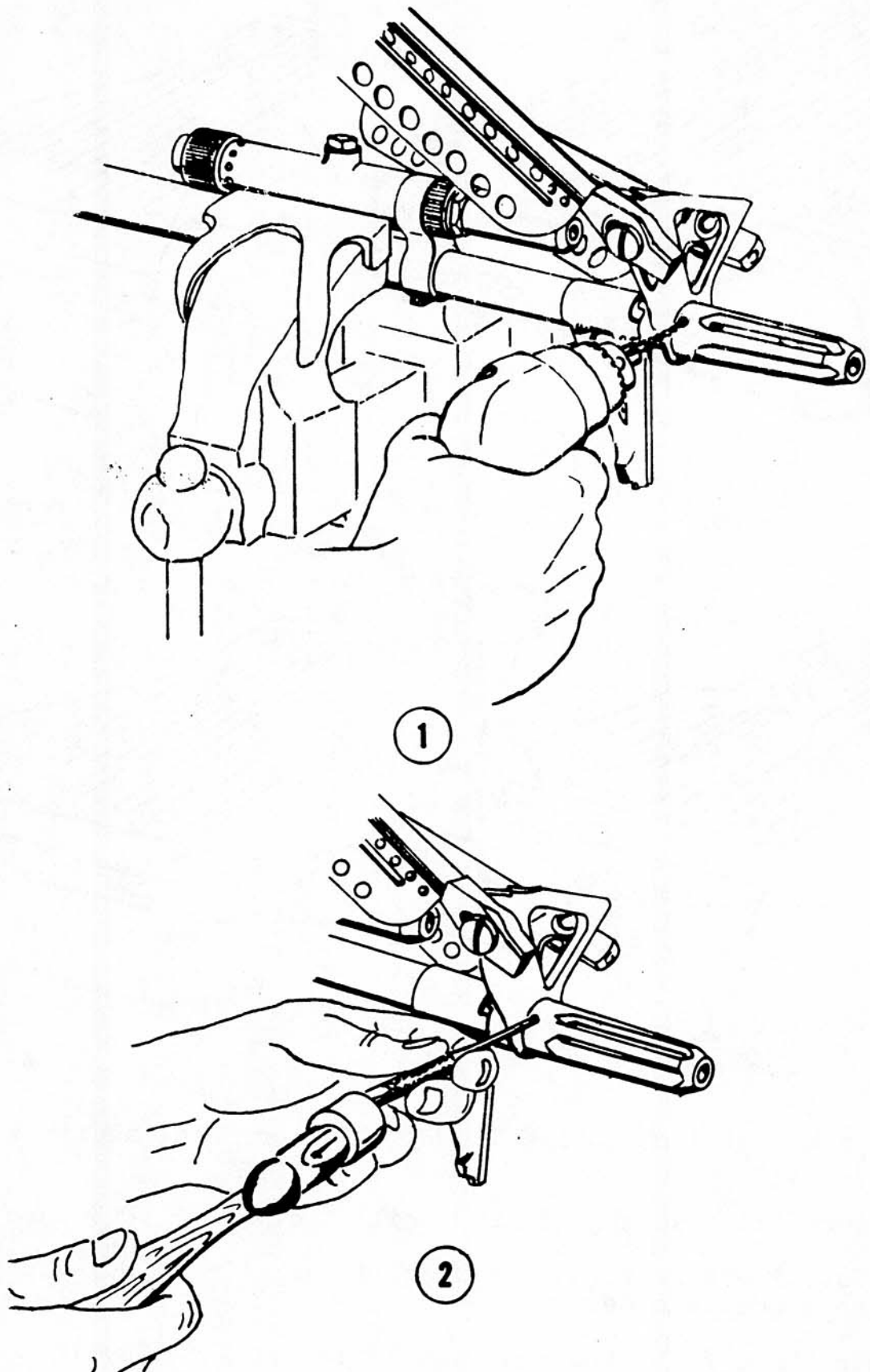
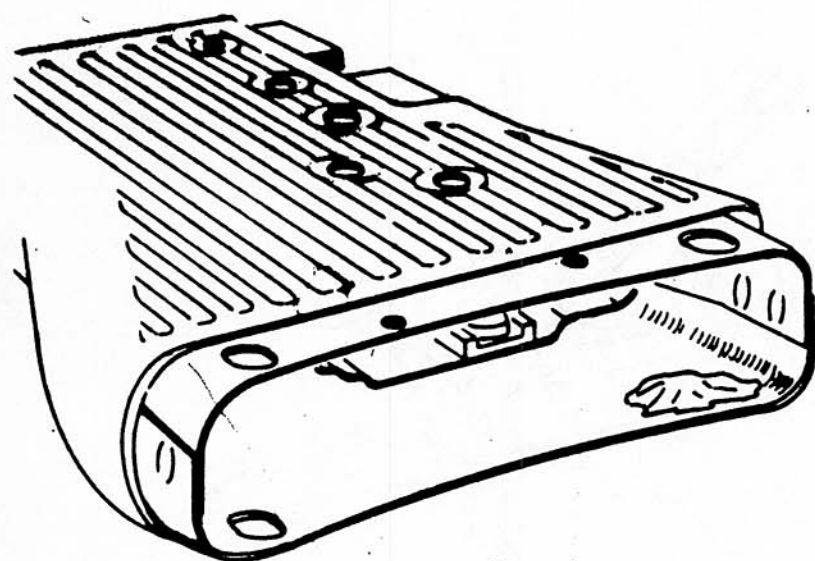
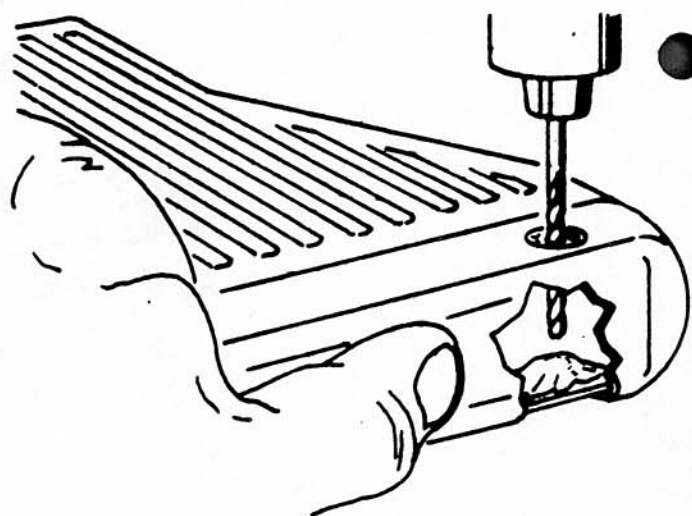


FIGURE 30

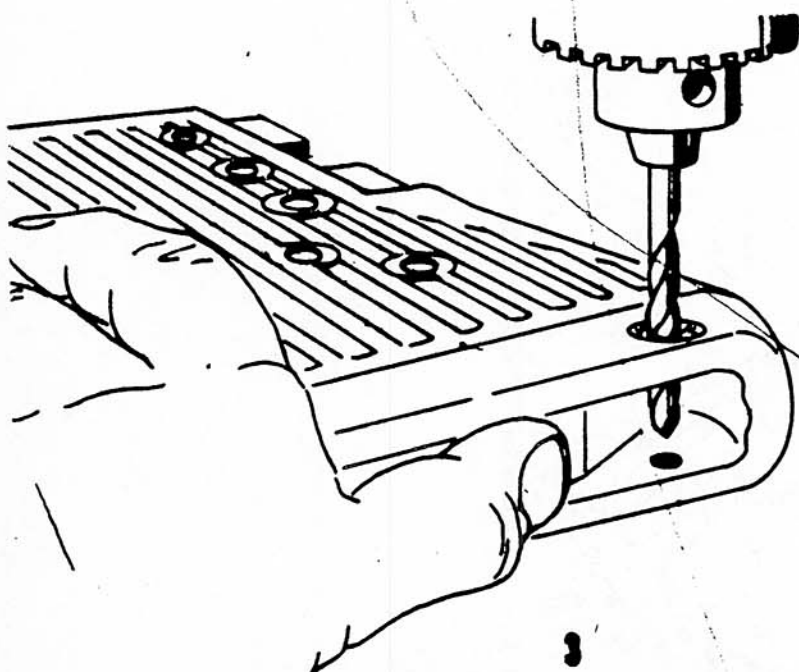
REMOVAL OF FLASH SUPPRESSOR M60 AND M60C



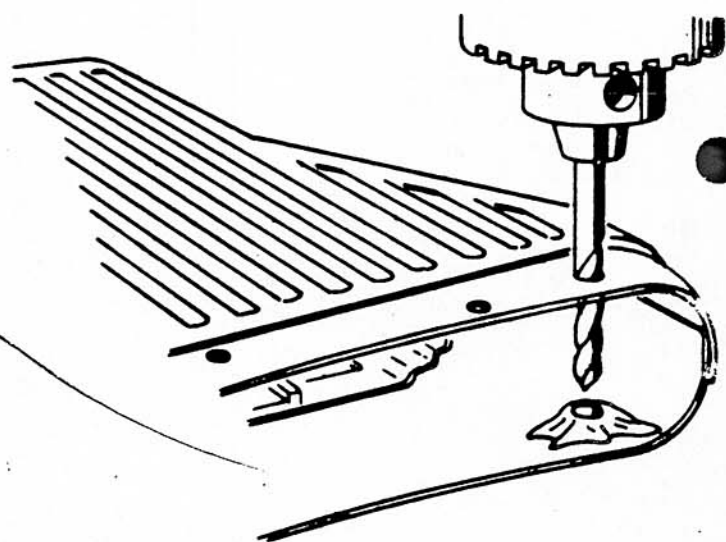
1



2



3



4

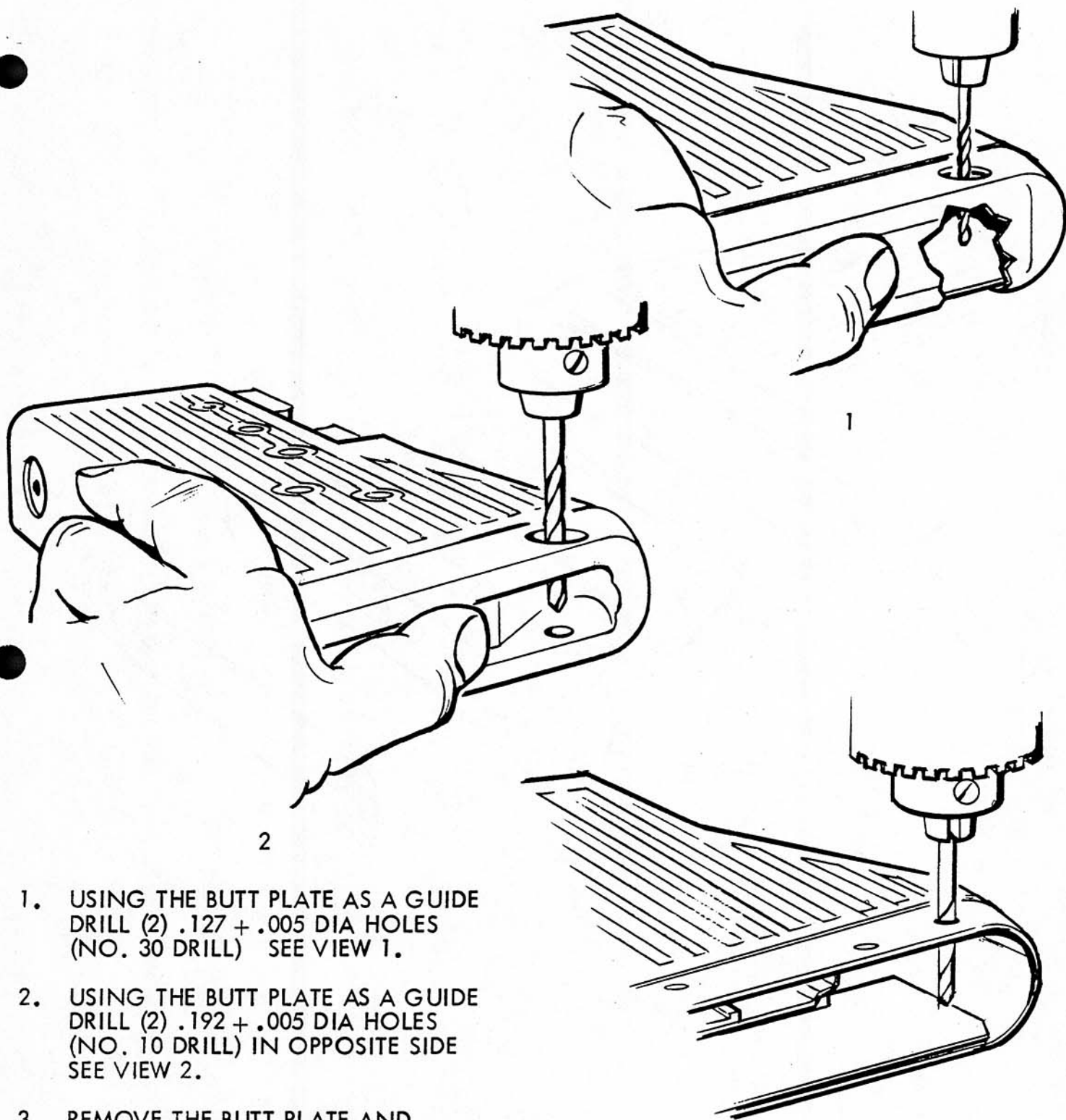
1. Create a 1/16 inch to 1/8 inch pad filler metal aluminum alloy 4043 or 5356.
2. Use Butt Plate as a guide and drill two .132 + .003 inch dia holes.
3. Use Butt Plate as a guide and drill two .195 + .003 inch dia holes on the opposite side.
4. Remove Butt Plate and redrill the two .132 + .003 inch dia holes, to .195 + .003 inch dia.

FIGURE 31
REPAIR OF BUTT STOCK M60

SUGGESTED PROCEDURE FOR REPAIRING M60 MG BUTT STOCK ASSEMBLIES

1. Remove butt stock. Refer to TM 9-1005-224-35.
2. Remove rivets securing the butt plate assembly as follows:

On right side of butt stock, centerpunch rivet heads, drill through head using 1/8 drill, punch out rivets.
3. Remove shoulder rest assembly.
4. Locate holes on both sides of butt stock as indicated in Fig. 31, Page 2. Spotface to remove rubber coating making certain not to remove metal.
5. Assemble plates as shown in View 3, Page 3. Clamp plates securely to prevent slipping during drilling and riveting. Before drilling, center punch all rivet locations. Drill two holes each side of butt stock and plates, see Page 3.
6. Remove all burs and clean away drill chips.
7. Rivet plates to butt stock using rivets FSN 5320-242-1582 MS 20470A6-4. Care must be taken to avoid damage to material being riveted.
8. Assemble butt plate to stock, seating it firmly against rubber shoulder. Using the butt plate as a template, drill holes as indicated in figure 3. Remove all chips.
9. With shoulder rest in butt plate, rivet butt plate to stock in accordance with figure 7.
10. Touch up rivets and bright areas with dark grey or black quick drying synthetic primer or lacquer, unaffected by preservatives used with the item.
11. Install butt stock. Refer to TM 9-1005-224-35.



1. USING THE BUTT PLATE AS A GUIDE
DRILL (2) $.127 + .005$ DIA HOLES
(NO. 30 DRILL) SEE VIEW 1.
2. USING THE BUTT PLATE AS A GUIDE
DRILL (2) $.192 + .005$ DIA HOLES
(NO. 10 DRILL) IN OPPOSITE SIDE
SEE VIEW 2.
3. REMOVE THE BUTT PLATE AND
FINISH DRILL (2) $.127 + .005$ DIA
HOLES, TO $.192 + .005$ DIA IN
FRAME ASSEMBLY SEE VIEW 3.

FIGURE 31
PAGE 3 OF 7

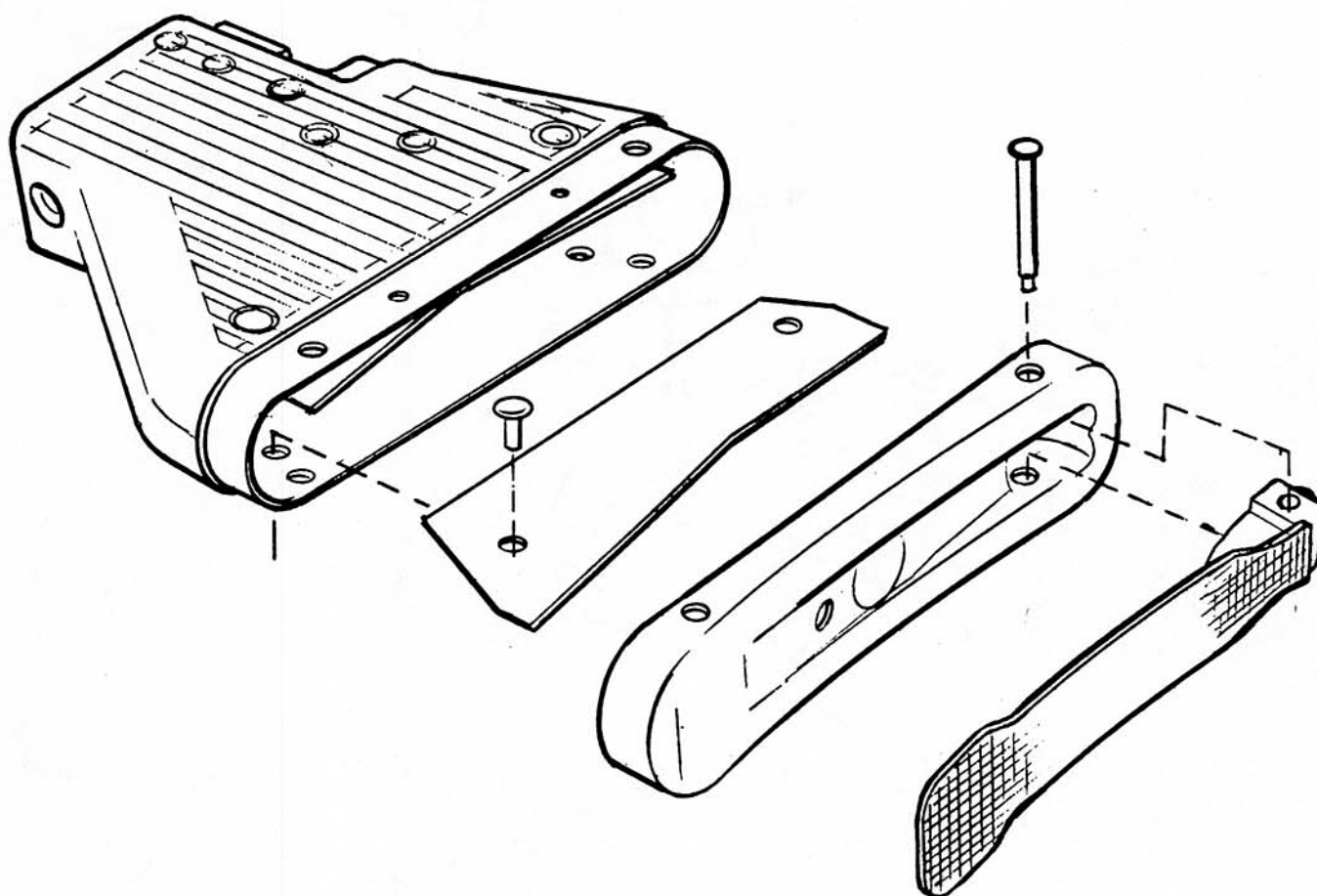


FIGURE 31
PAGE 4 OF 7

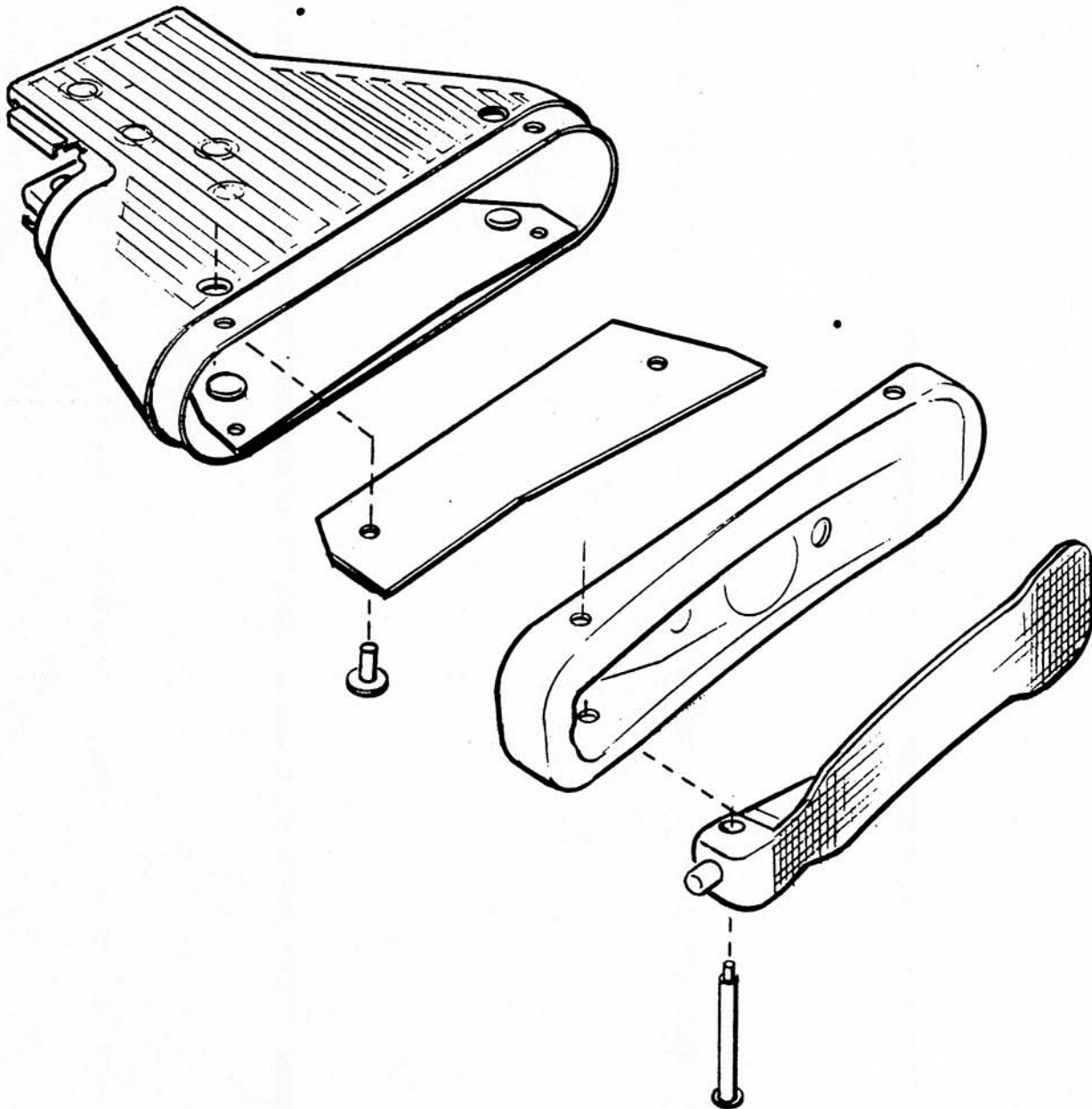
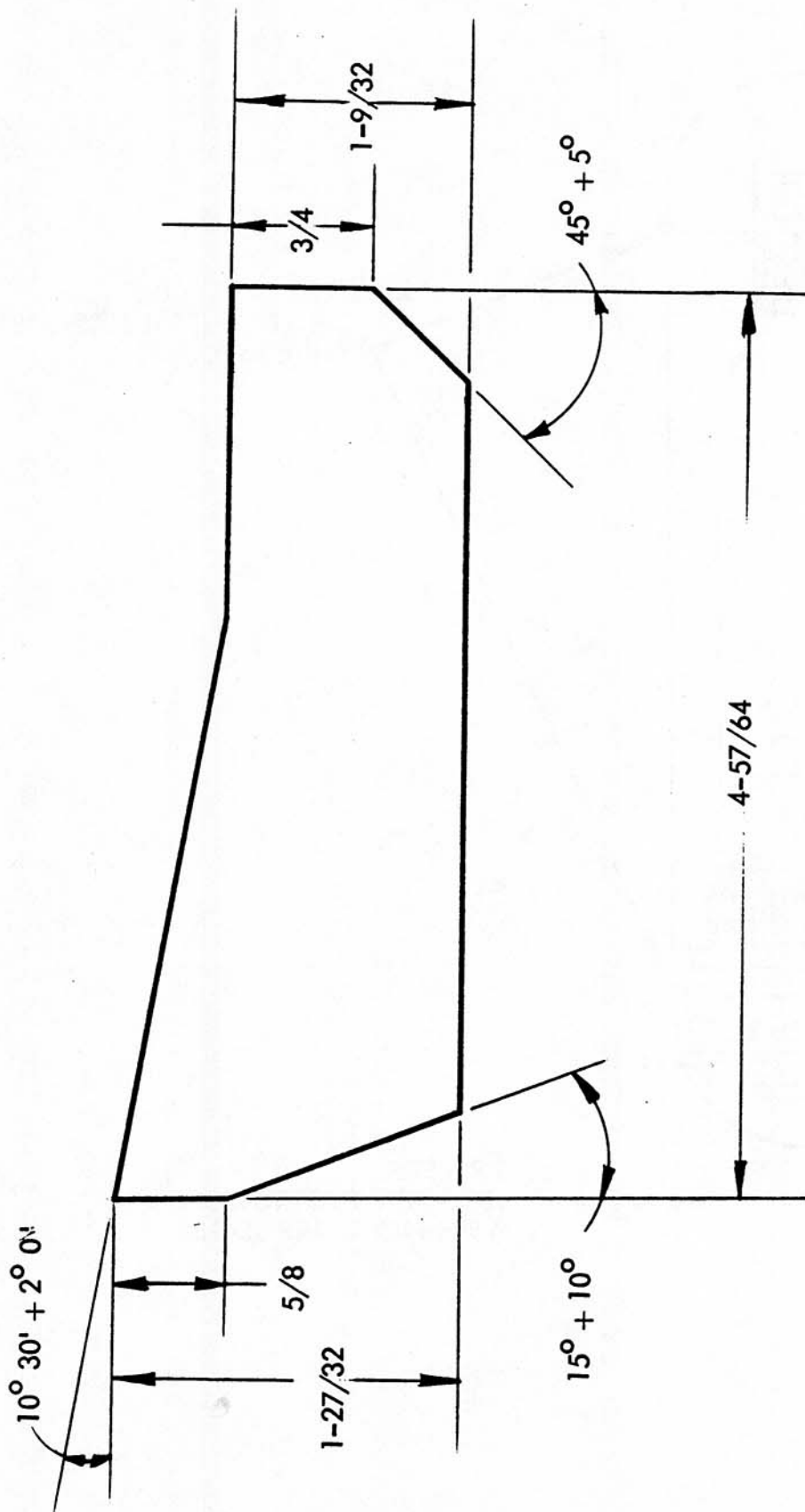


FIGURE 31
PAGE 5 OF 7

NOTE: ALL DIMENSIONS SHOWN ARE IN INCHES.



MATERIAL: 18 GAGE STEEL STRIP CR 1010-1020 (FED SPEC QQ-S-698)
 PROTECTIVE FINISH: PHOSPHATE COATING WITH TYPE M OR TYPE Z,
 CLASS 1 OF MIL-P-16232

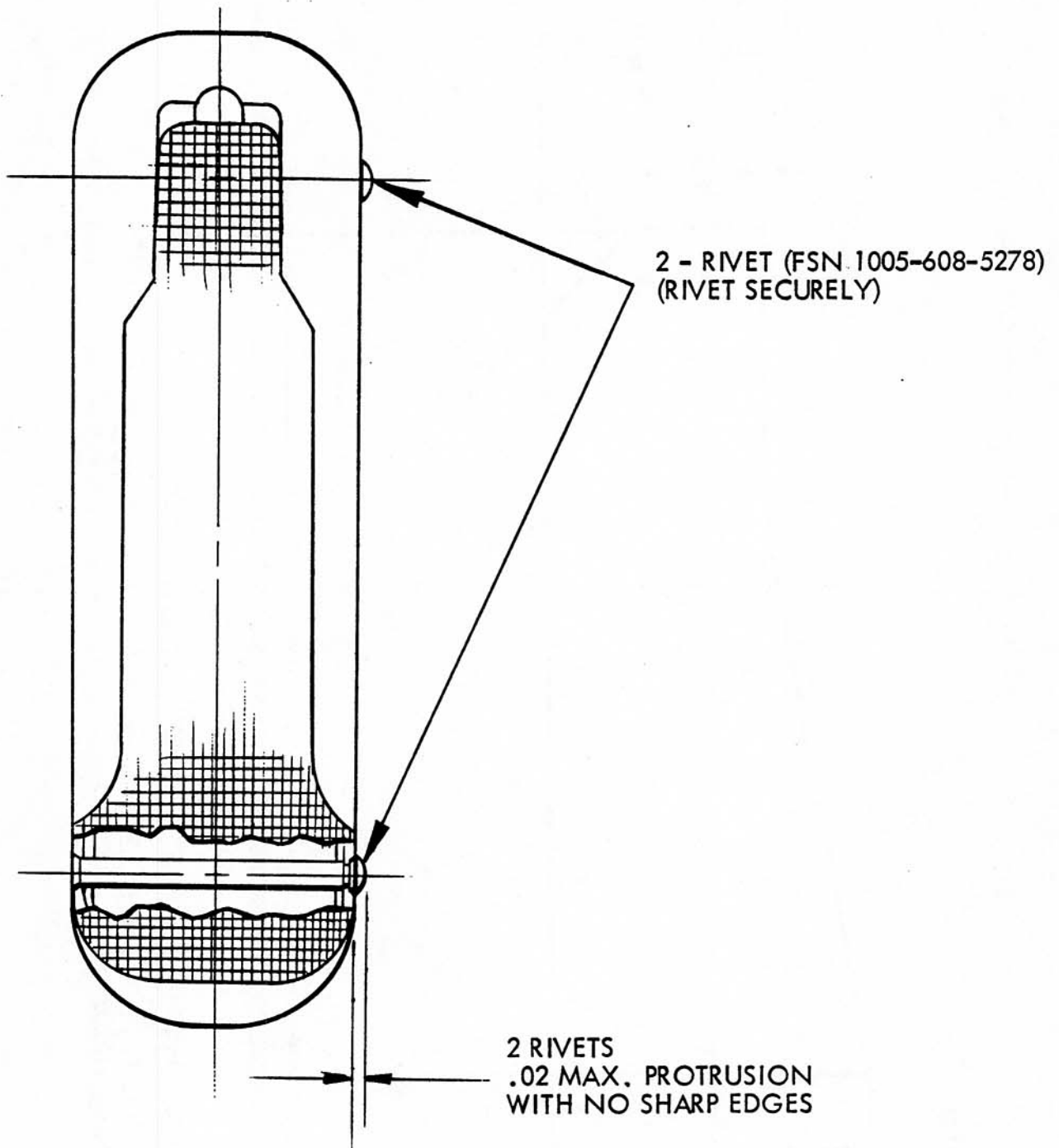


FIGURE 31
PAGE 7 OF 7

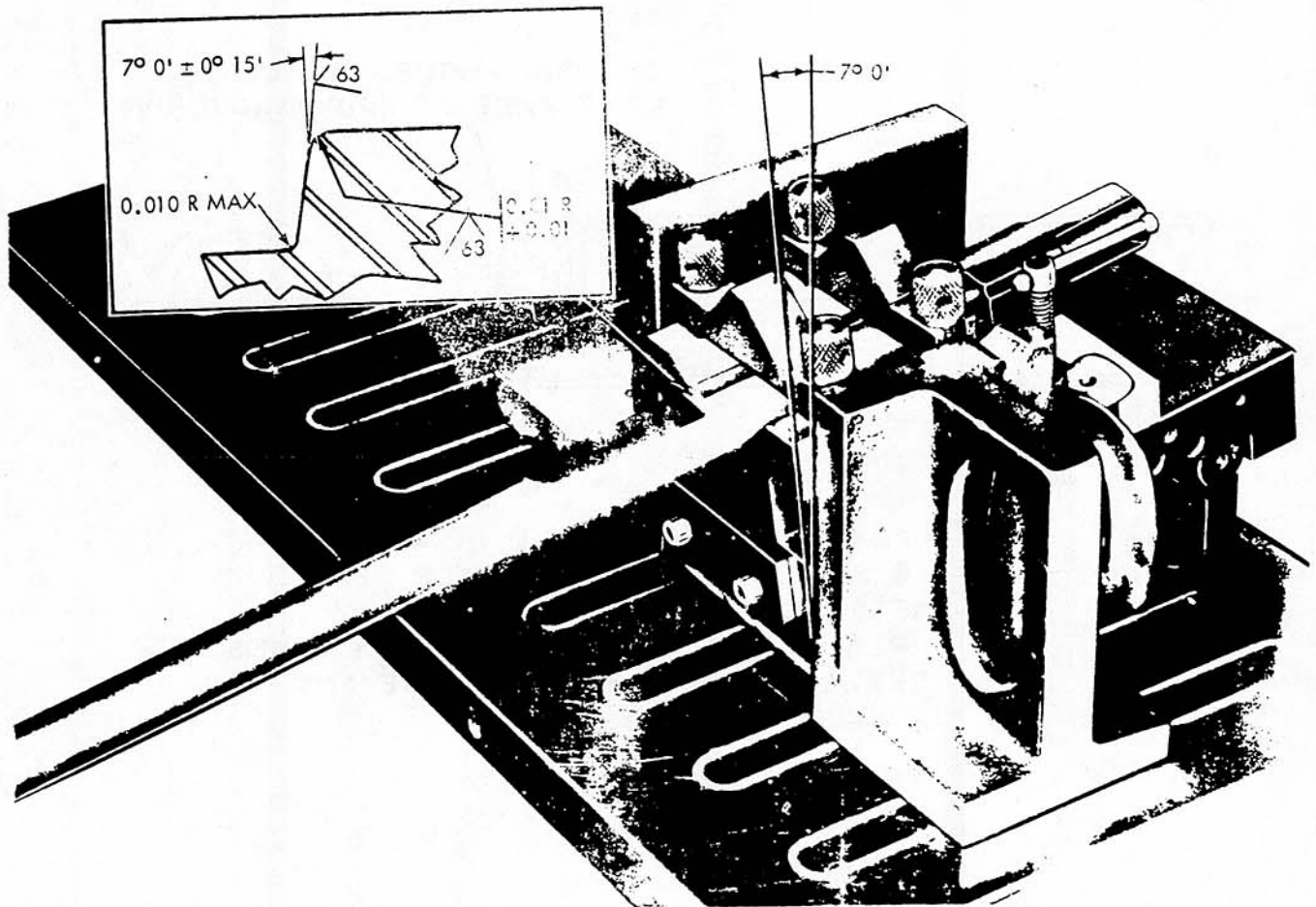
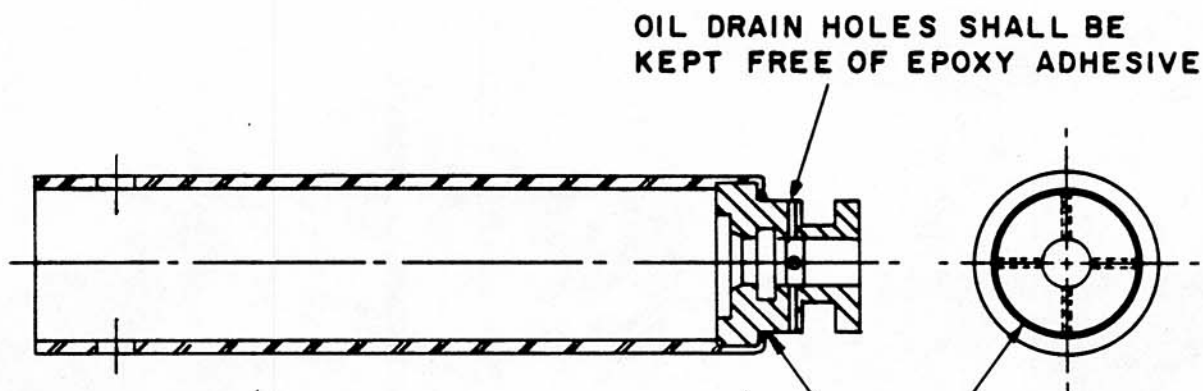


FIGURE 32

GRIND SEAR NOTCH M60 AND M60C



**EPOXY ADHESIVE SHALL BE APPLIED
AS SHOWN WITHOUT EVIDENCE OF BREAKS
AFTER CURING.
AREA TO BE FILLED WITH EPOXY ADHESIVE
SHALL BE FREE OF OIL, GREASE AND
FOREIGN MATTER.**

FIGURE 33

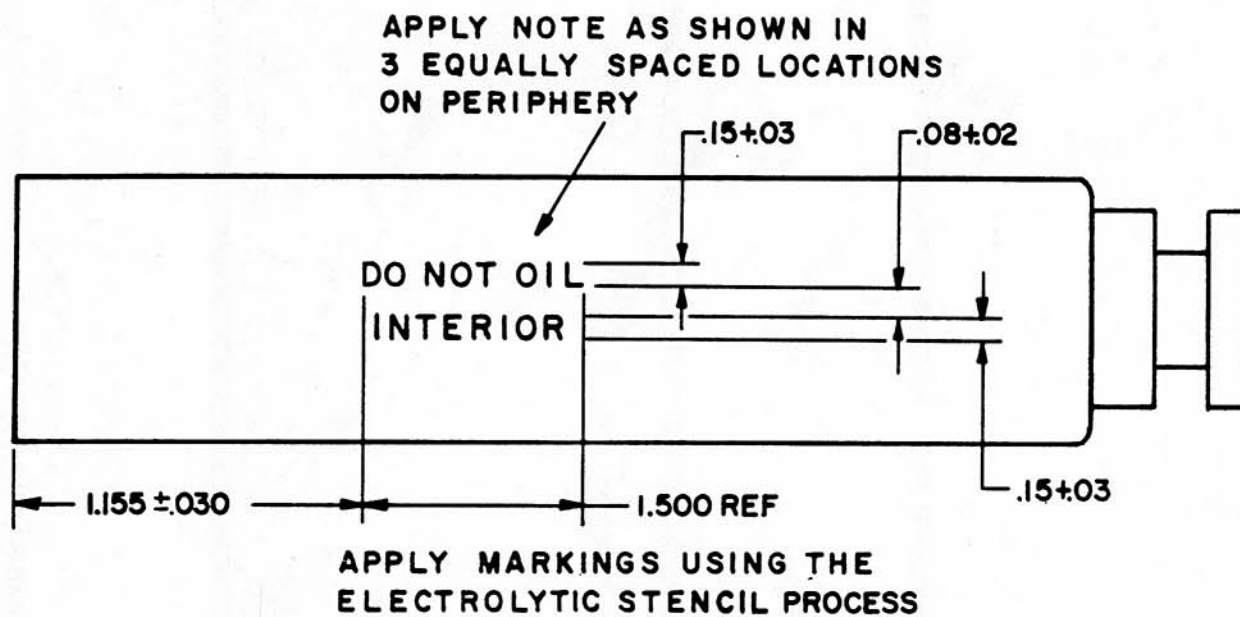
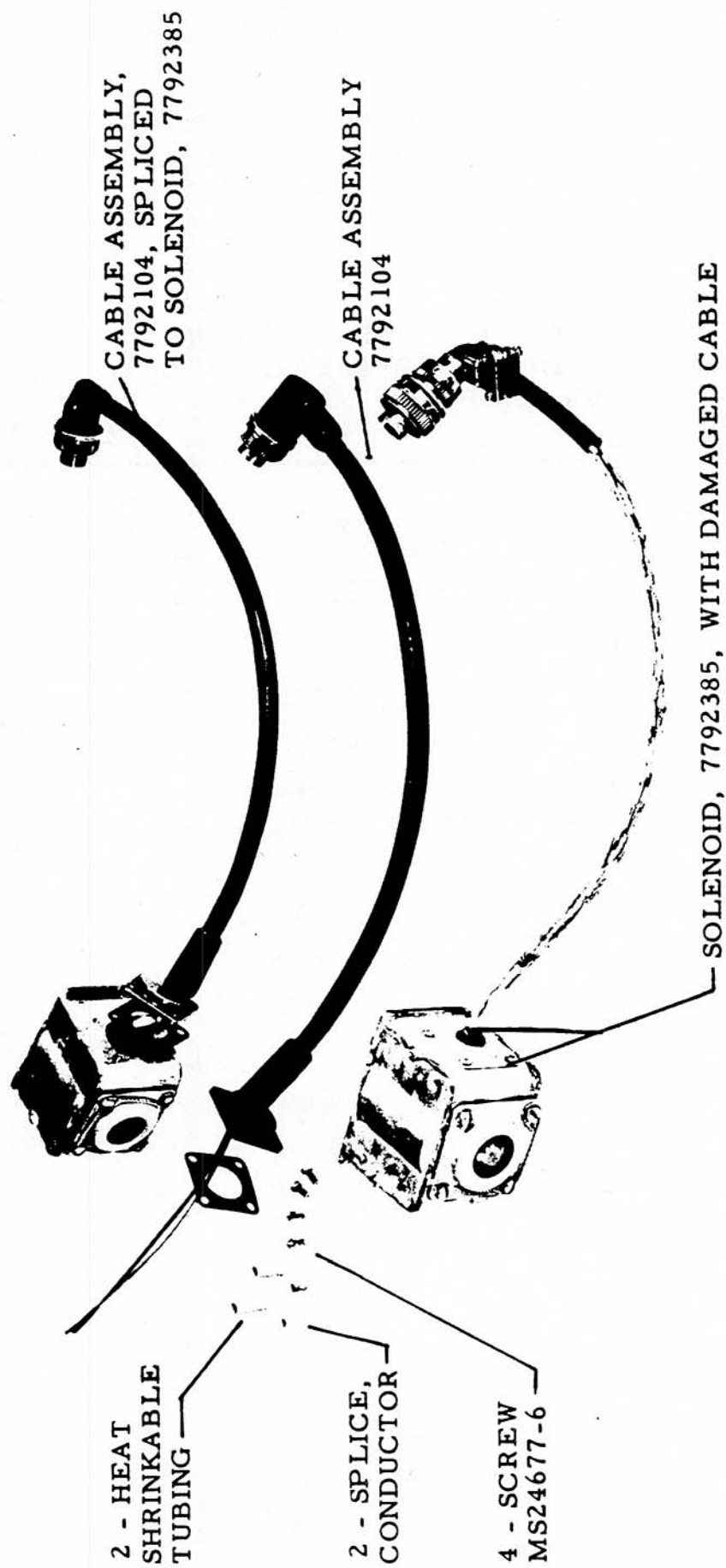


FIGURE 34

MARKING OF BUFFER ASSEMBLY M60 AND M60 C

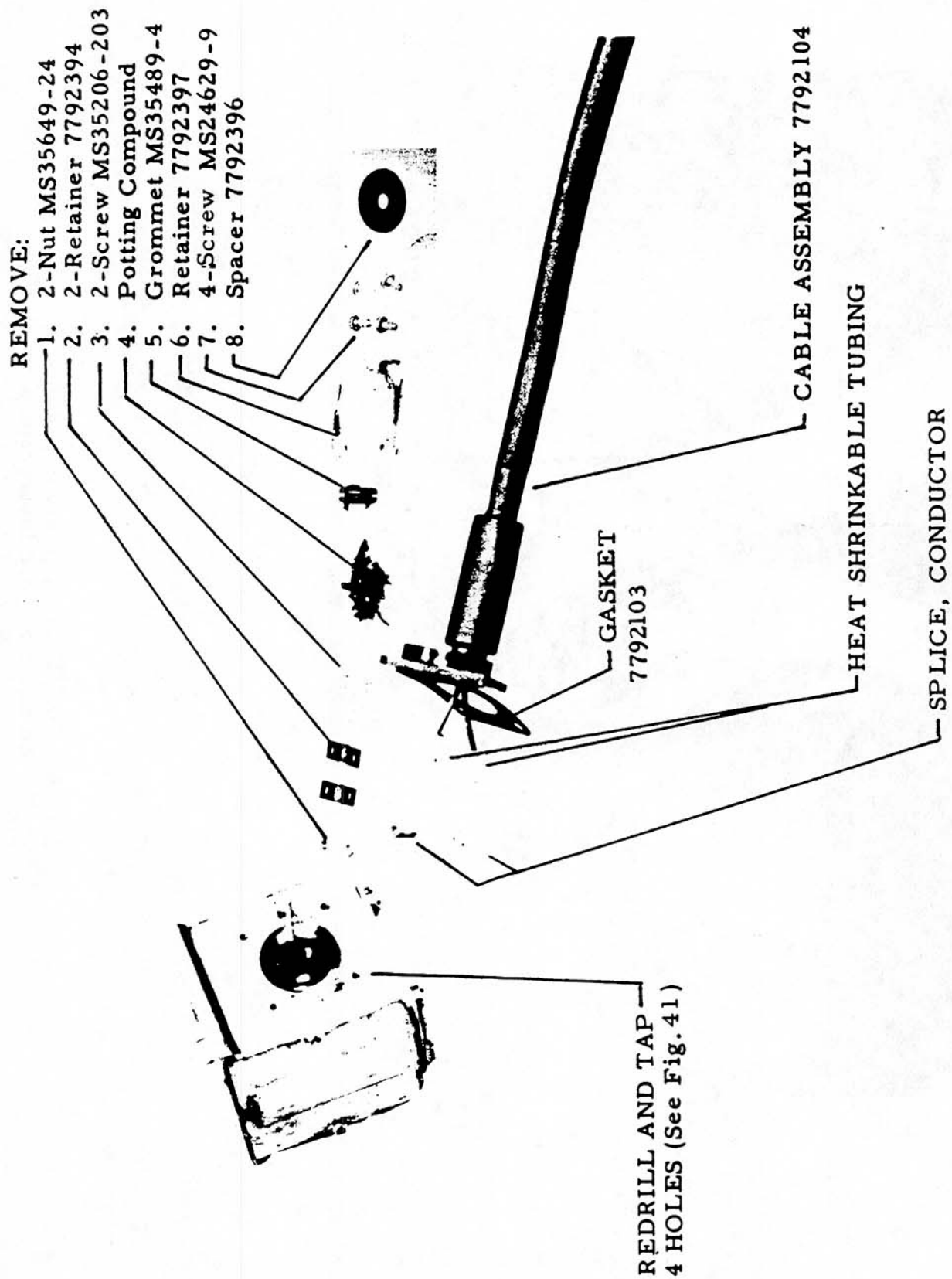


MACHINE GUN, 7.62mm: M60C
Solenoid Repair Instructions.
Fig. 35



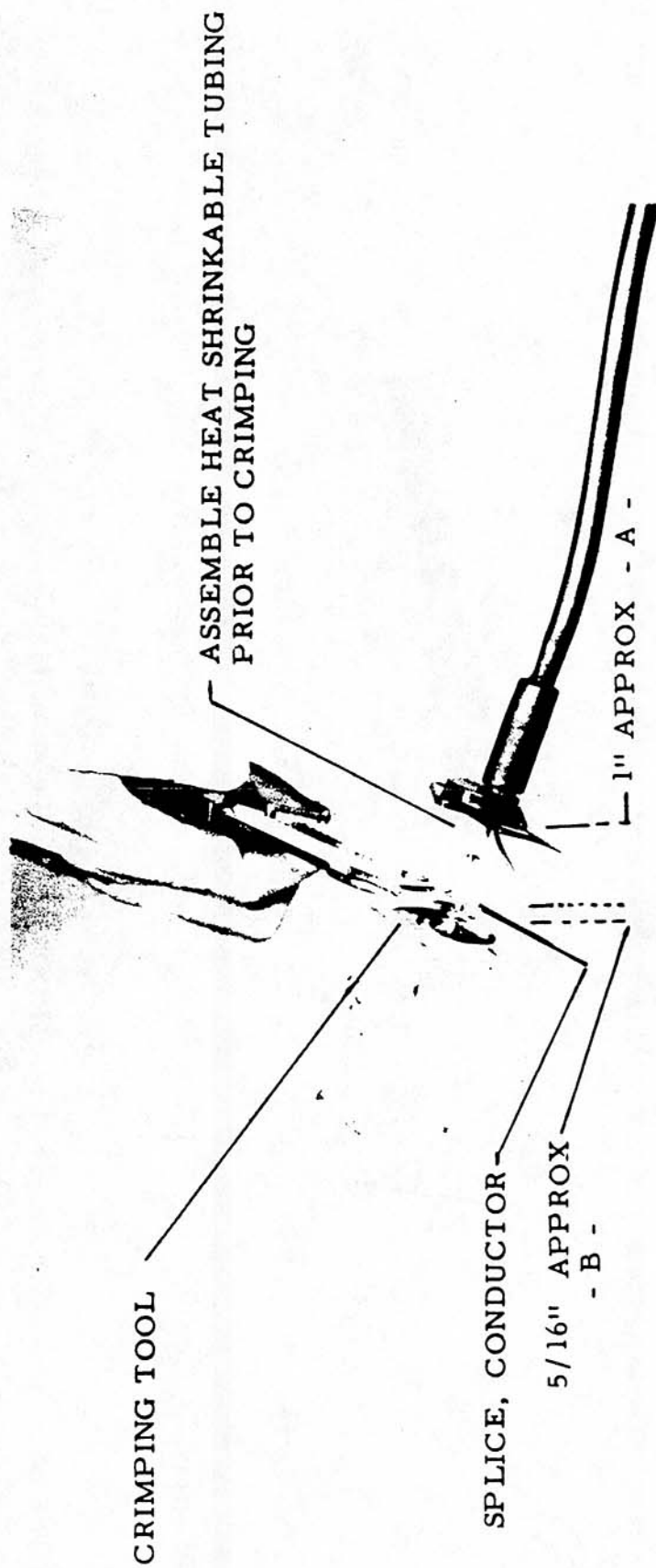
CUT UNSERVICEABLE CABLE HERE
(MINIMUM)

MACHINE GUN, 7.62mm: M60C
Solenoid Repair Instructions.
Fig. 36



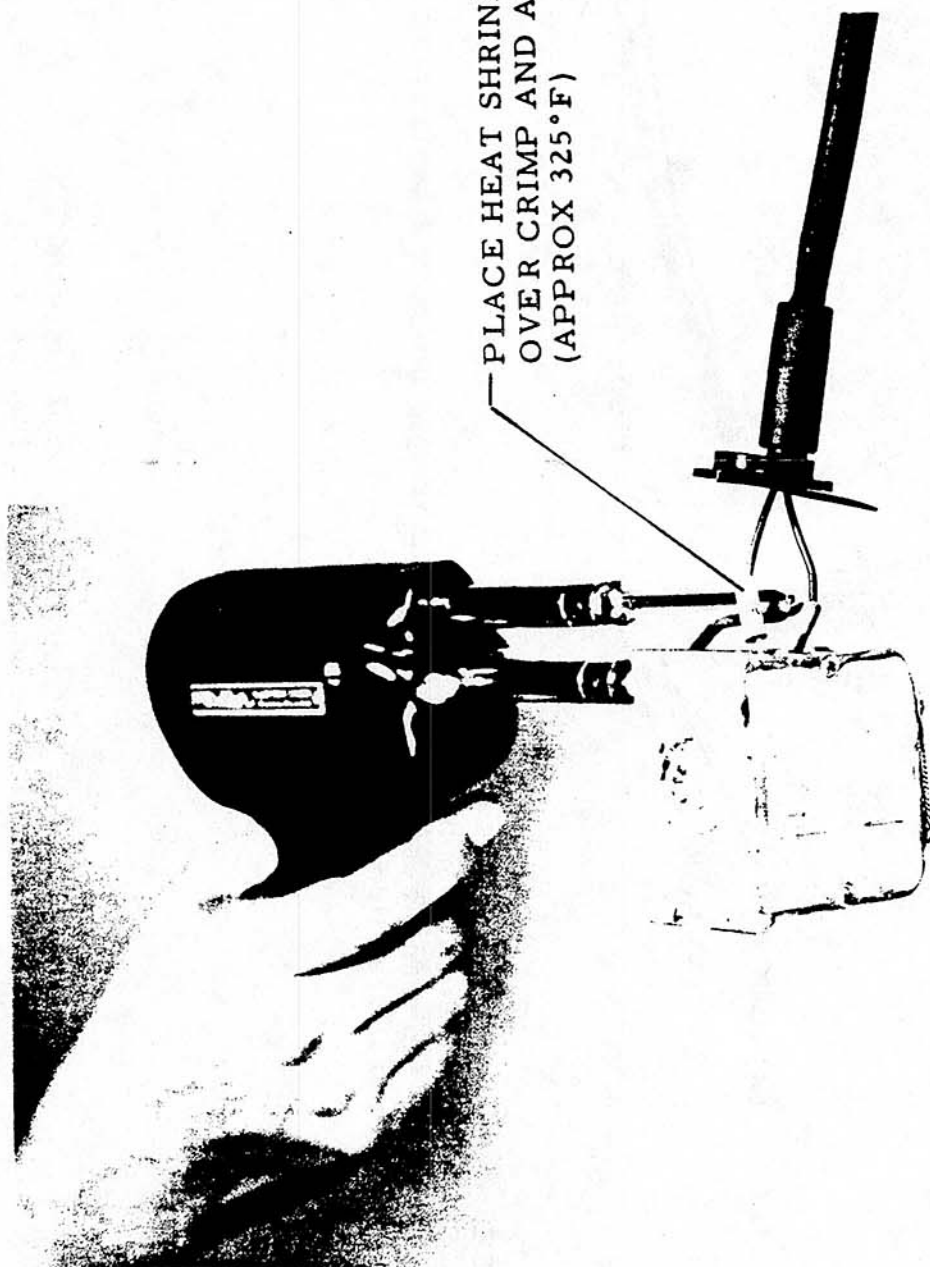
MACHINE GUN, 7.62mm: M60C
Solenoid Repair Instructions.

Fig.

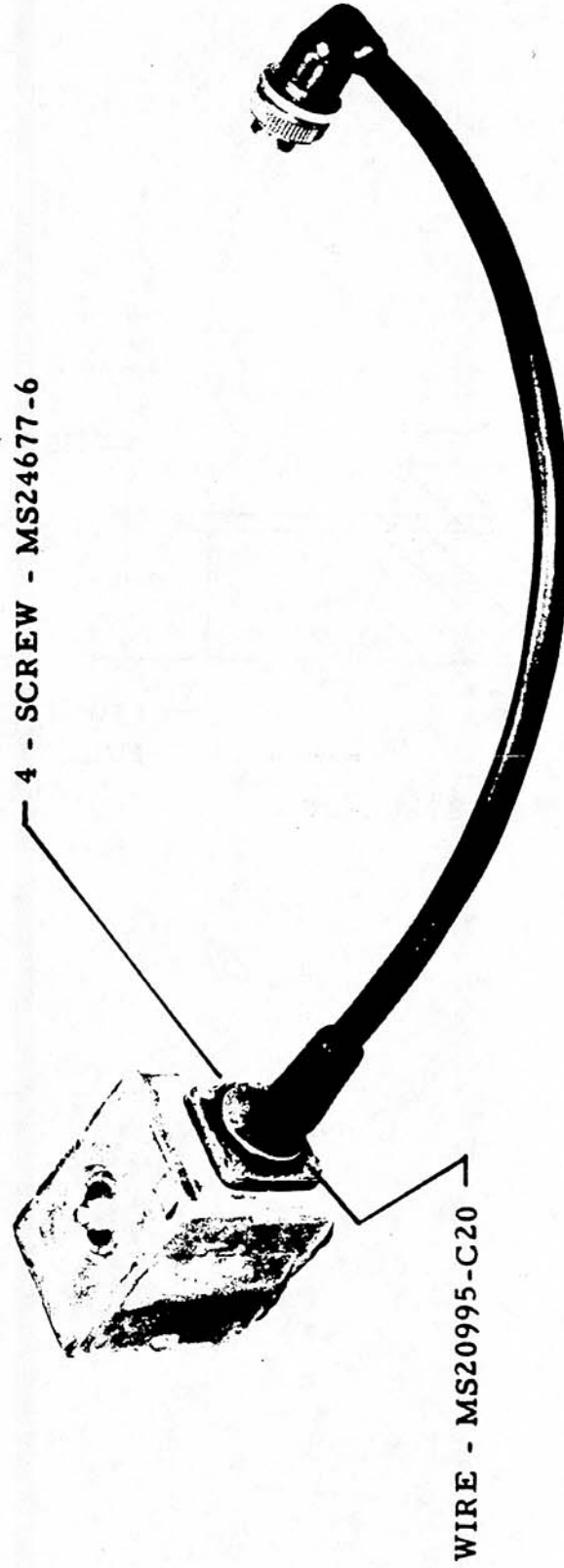


NOTE:

1. Cut cable assembly conductors length - A -
2. Skin 2 solenoid and 2 cable conductors length - B -
3. Make a parallel splice and crimp



MACHINE GUN, 7.62mm; M60C
Solenoid Repair Instructions.
Fig. 39



MACHINE GUN, 7.62mm: M60C
Solenoid Repair Instructions.
Fig. 40

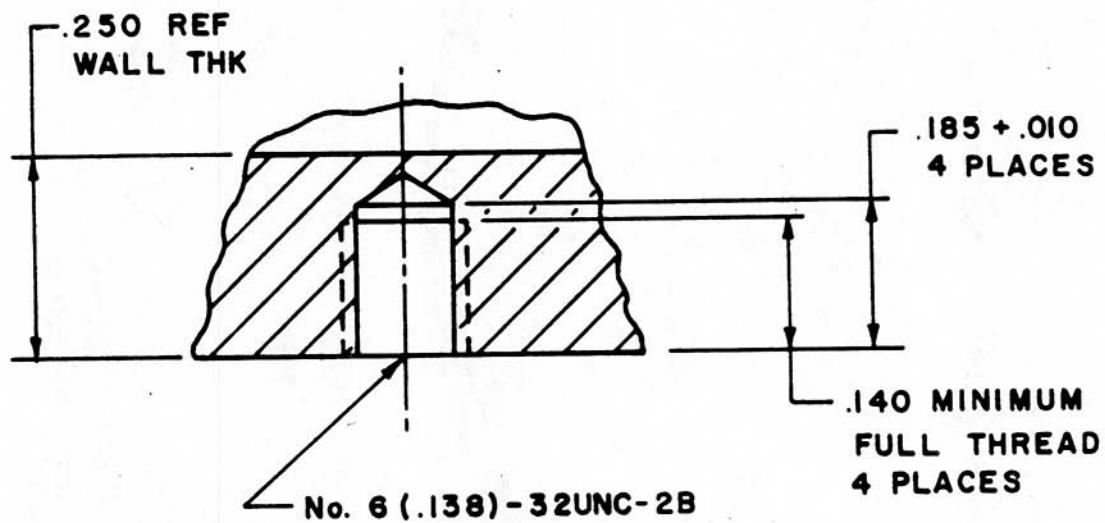
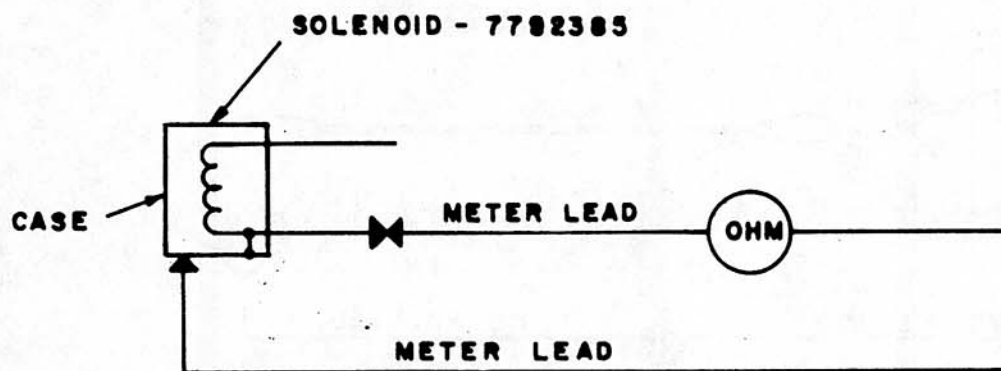
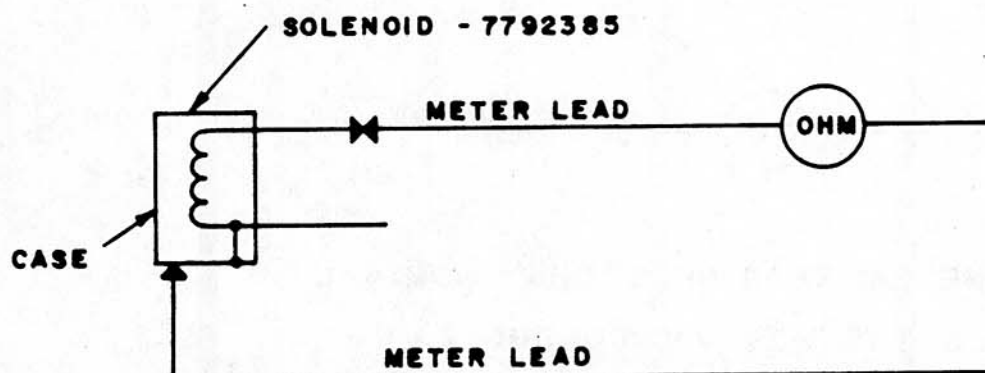


FIGURE 41



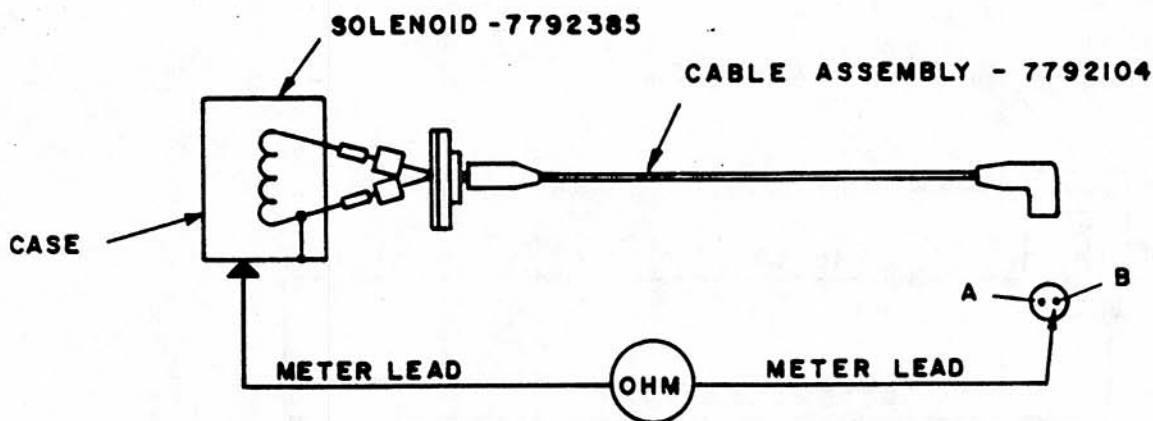
AN OHMMETER READING OF "0" OHMS
INDICATES THE "0" VDC CONDUCTOR.

A



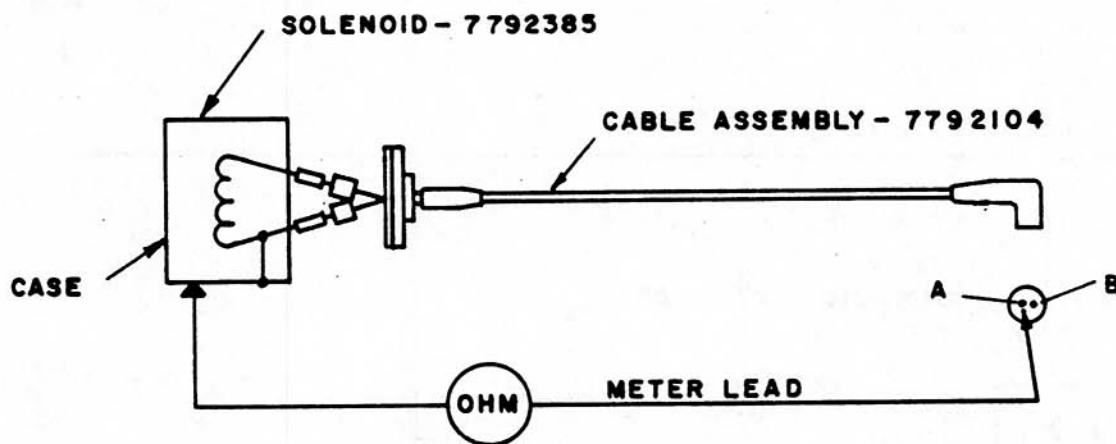
AN OHMMETER READING OF "5" OHMS NOMINAL
INDICATES THE "+ 28" VDC CONDUCTOR.

FIGURE 42



AN OHMMETER READING OF "0" OHMS INDICATES
THE "0" VDC CONDUCTOR

A



AN OHMMETER READ OF "5" OHMS NOMINAL
INDICATES THE "+ 28" VDC CONDUCTOR

B

FIGURE 43

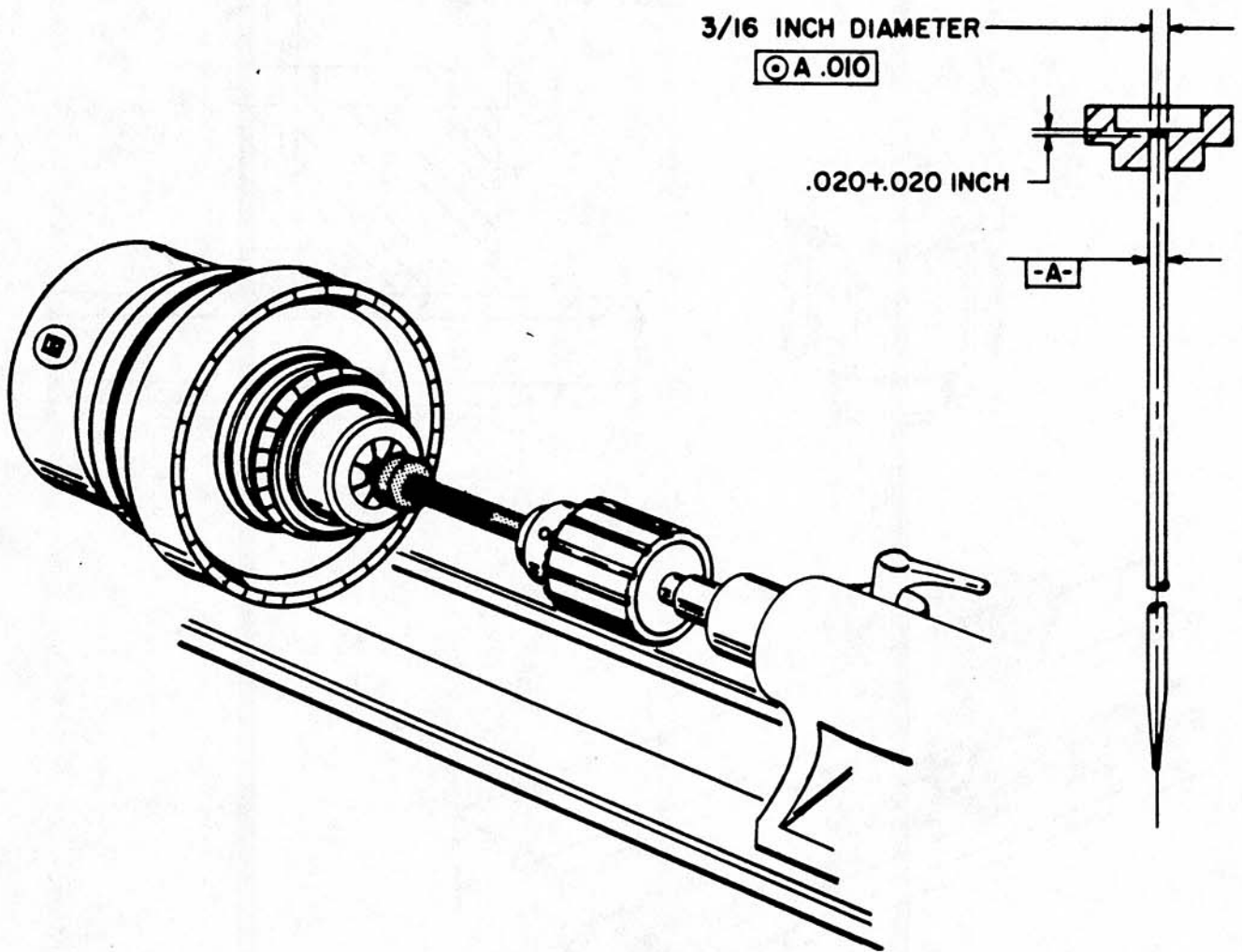


FIGURE 44

REPAIR OF GUIDE ROD ASSEMBLY M60 AND M60C

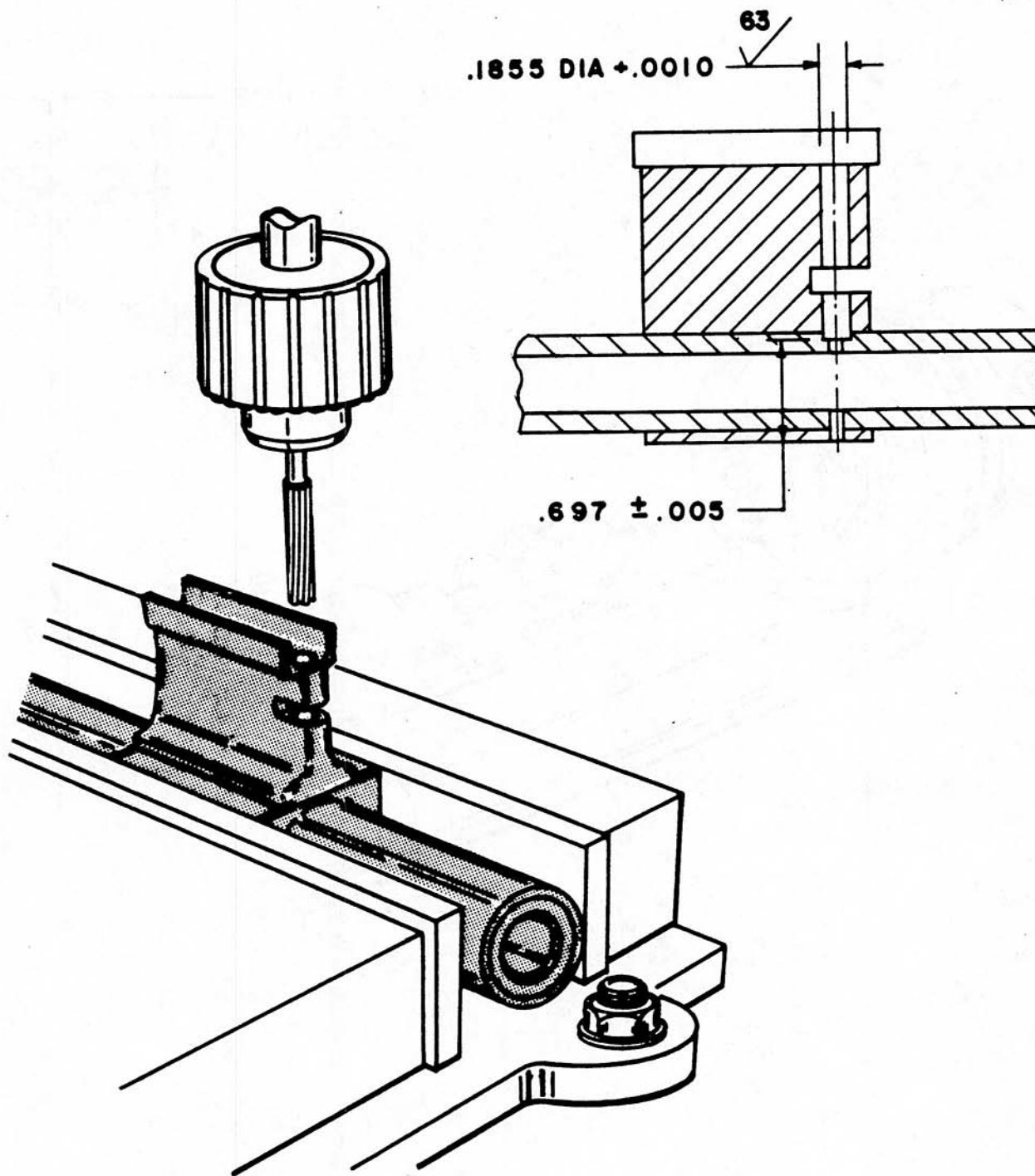


FIGURE 45

REPAIR OF OPERATING ROD ASSEMBLY M60 AND M60C

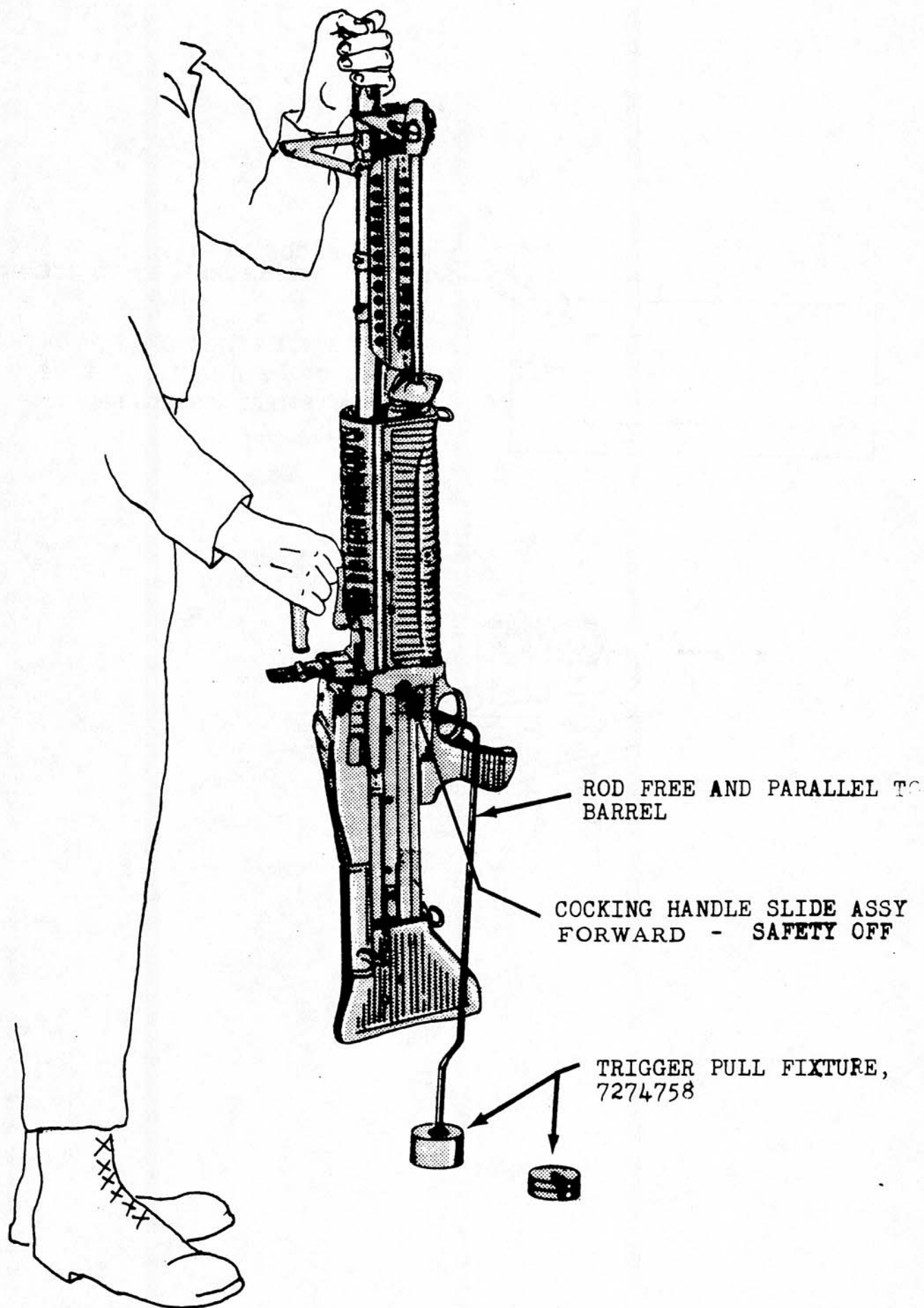


FIGURE 46

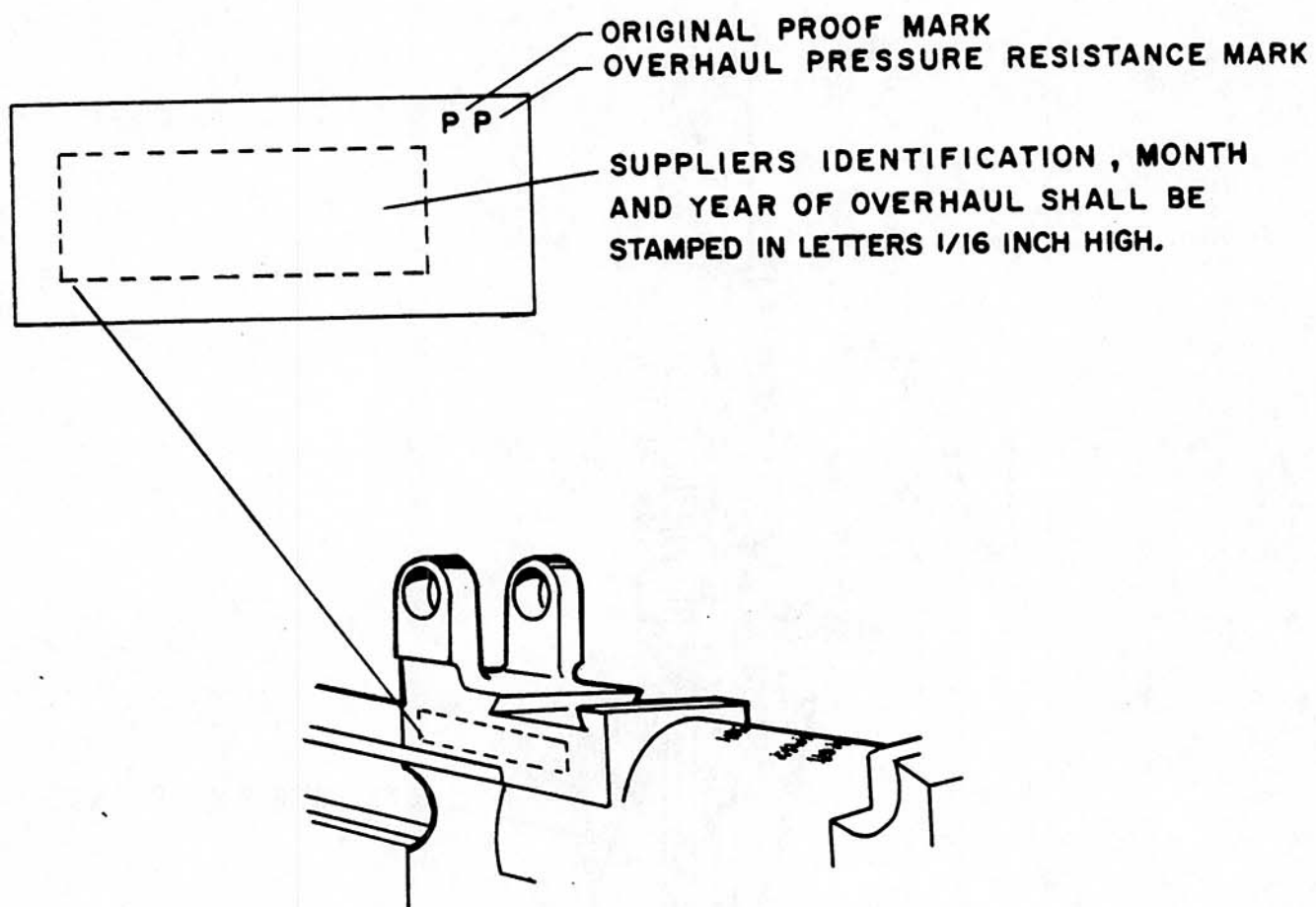
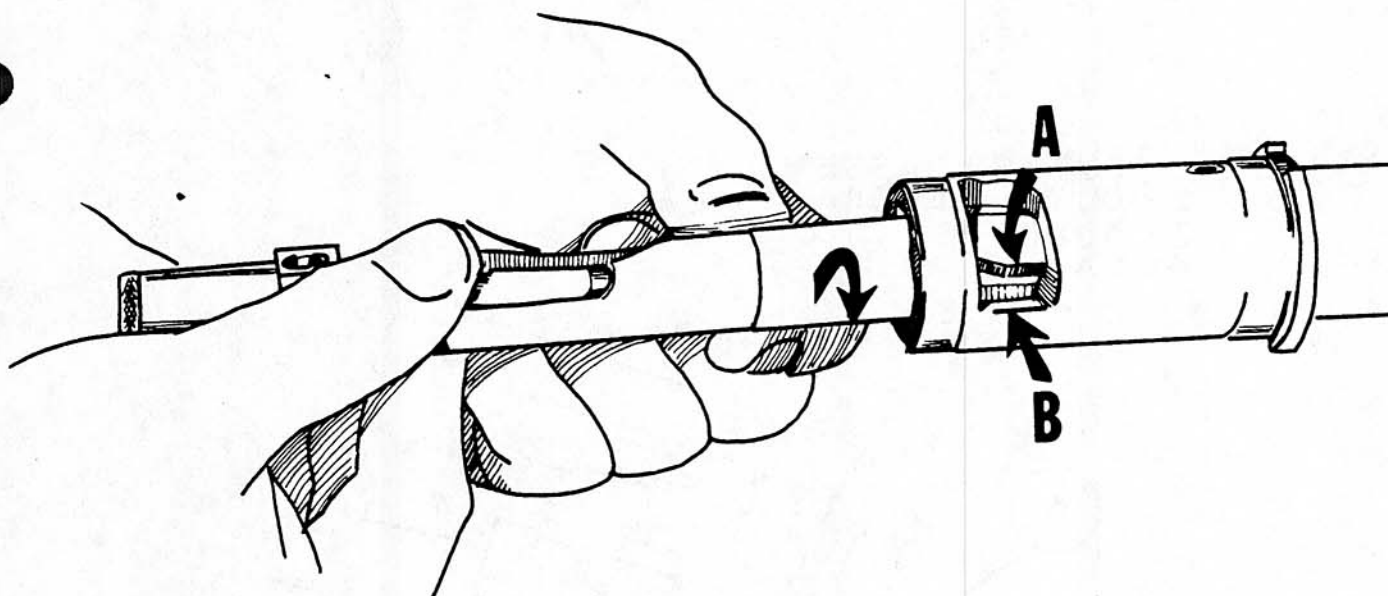
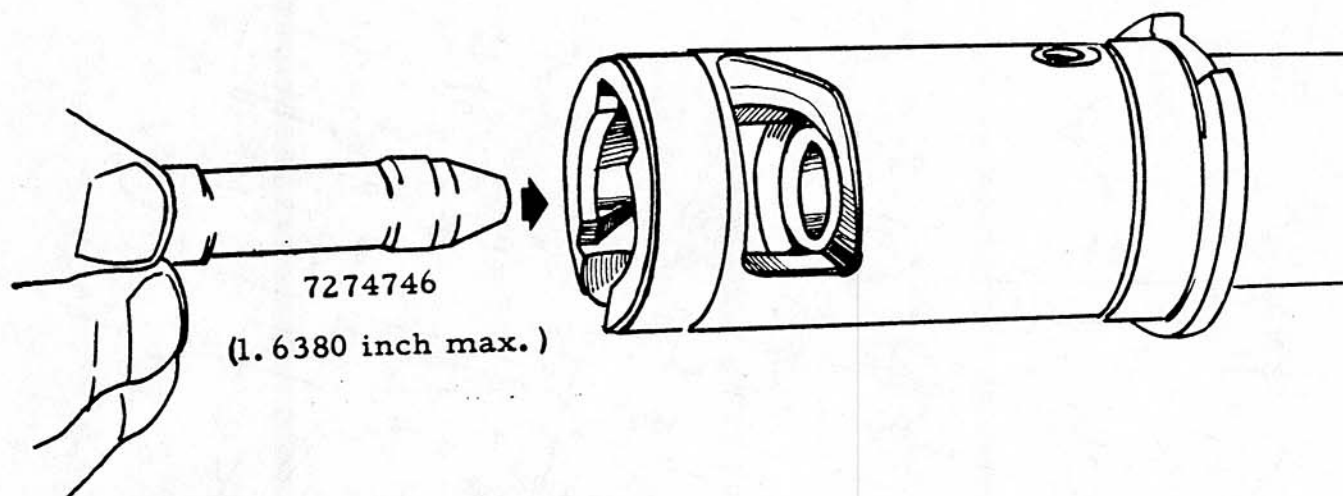


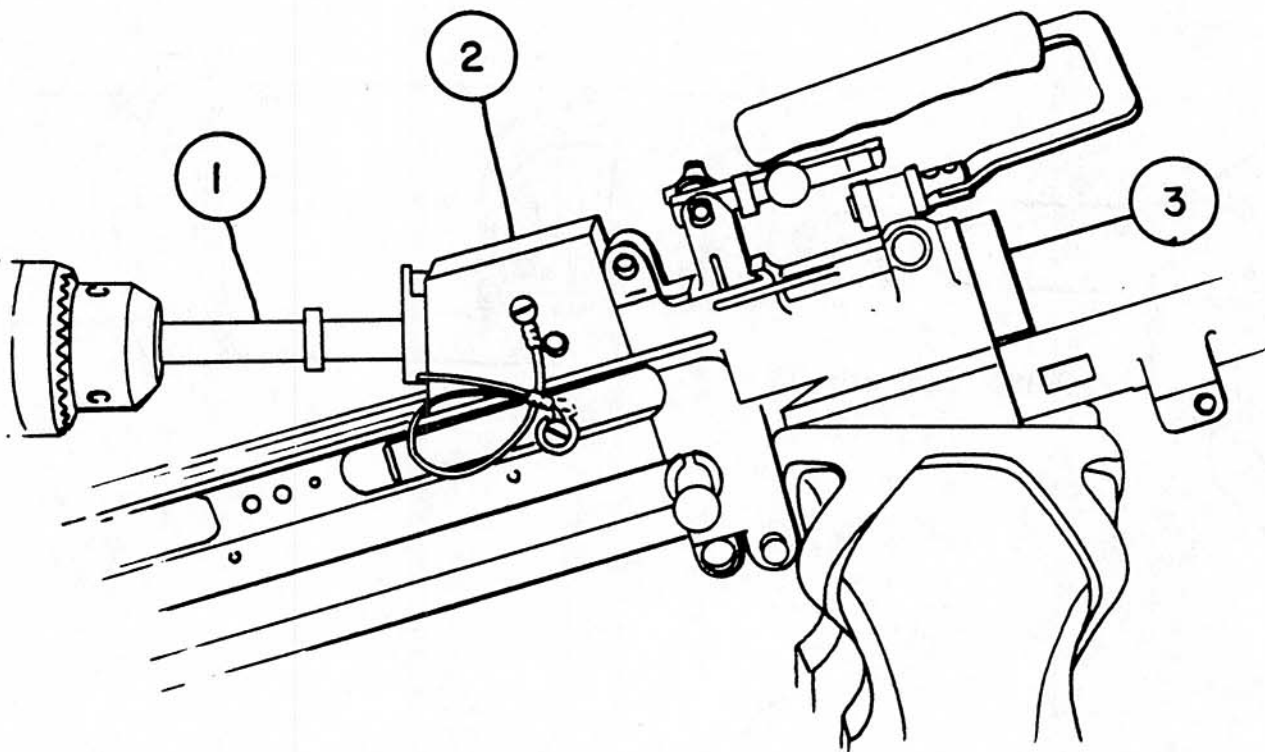
FIGURE 47



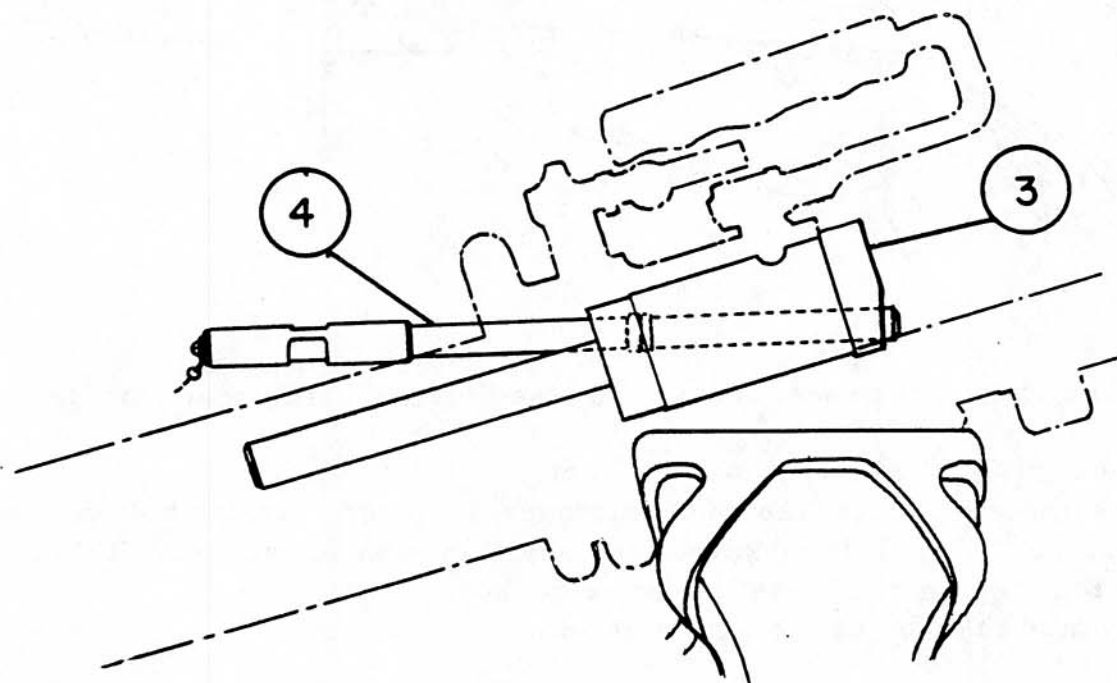
The following procedure will be used for checking headspace:

1. Insert plug (7274746) into chamber.
2. Assemble gun bolt (7269060) into barrel socket, rotate bolt clockwise.
3. Surface "A" of bolt locking lugs, shall not contact surface "B" of locking lug recesses in barrel socket.
4. Contact shall be cause for rejection.

FIGURE 48



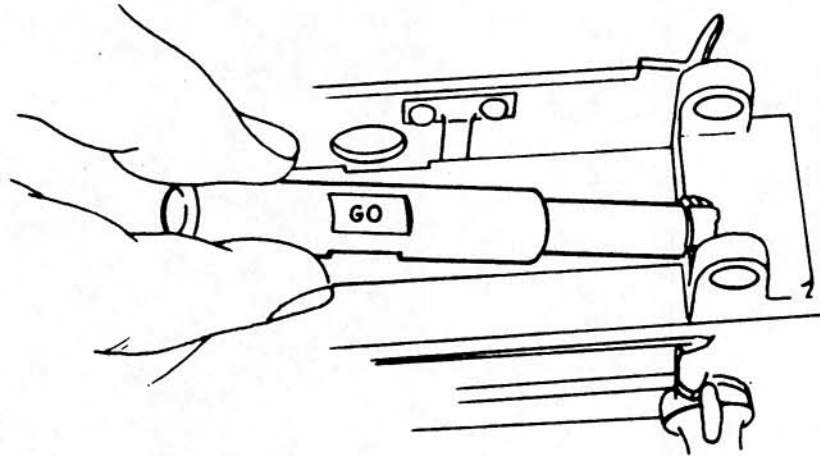
1. CUTTER ASSEMBLY
2. GUIDE BLOCK
3. ADAPTOR
4. GAGING PLUG



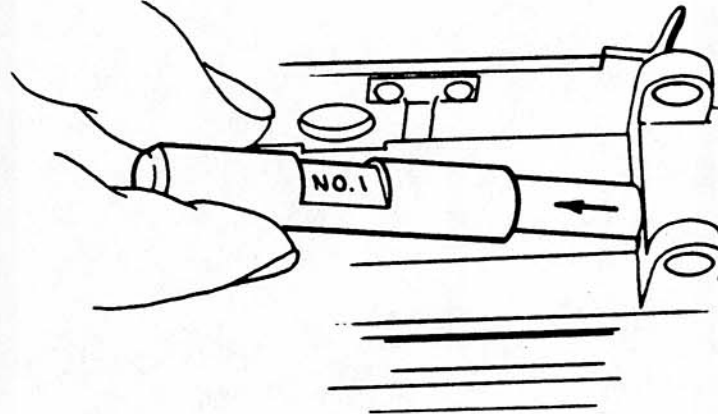
RECEIVER MODIFICATION PROCEDURE

STEP 1- "NOT SHOWN"

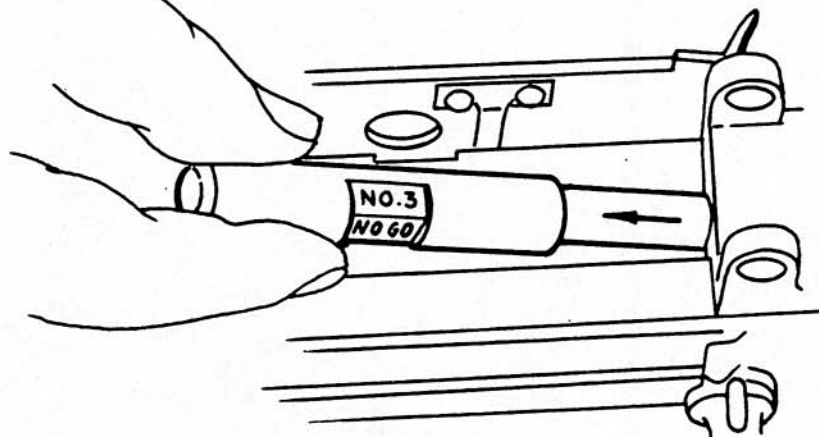
WITH "NOT GO" FACING UP, THE PLUG
MUST NOT ENTER RECEIVER



**STEP 2- WITH "GO" FACING UP, THE PLUG MUST
ENTER UNTIL NOTCH IS IN LINE WITH
RECEIVER**



**STEP 3- WITH "NOT GO" NO.1 FACING UP, THE PLUG
MUST NOT BE ABLE TO BE PULLED OUT
OF RECEIVER**



**STEP 4- WITH "NOT GO" NO.3 FACING UP, THE PLUG
MUST NOT BE ABLE TO BE PULLED OUT
OF RECEIVER**

PART II

INDEX OF OVERHAUL INSPECTION PROCEDURES
APPLICABLE TO BOTH
Machine Guns 7.62MM, M60 and M60C

<u>OIP NUMBER</u>	<u>NOMENCLATURE DESCRIPTION</u>
7269063	Actuator Assembly, Cam
7269065	Bearing, Firing Pin
7269060	Bolt
7269097	Cap, Buffer
11010292	Channel Assembly, Feed Cam
7269146	Clip, Spring, Lever
7790555	Clip, Retaining (See OIP-11010181)
7269098	Cover, Buffer
11010375	Ejector
7269030	Extension, Gas Cylinder
7790907	Extractor
7792097	Frame Assembly, Cartridge Tray
7269199	Guide Assembly
7269116	Guide, Cartridge, Front
7269117	Guide, Cartridge, Rear
11010155	Guide, Cocking Handle
7269099	Housing Assembly, Buffer
7269118	Housing Assembly, Cover
7269243	Latch, Hinge Pin
7790553	Latch, Magazine
7790554	Latch, Magazine Release
7269244	Lever, Barrel Lock
7269145	Lever, Feed
7269031	Nut, Gas Cylinder
7269120	Pawl Assembly, Feed
7269332	Pawl, Cartridge Retainer
11010181	Pin, Cotter
7269081	Pin, Firing
7269247	Pin, Hinge, Cover
7792069	Pin, Latch
7792920	Pin, Lock
7269101	Pin, Lock, Cover
7269205	Pin, Retaining
7269248	Pin, Spring Retainer
MS39086-81	Pin, Spring, Tubular, Coiled
7791247	Piston, Gas
7791600	Plug, Bolt
7792093	Plug, Gas Cylinder
7269249	Plunger, Barrel Lock

OIP NUMBERNOMENCLATURE DESCRIPTION

7269103	Plunger, Buffer
7269083	Plunger, Extractor
7269123	Plunger, Retainer
7269207	Plunger, Sear
7269251	Receiver Assembly
7269237	Retainer, Cocking Handle
7269084	Retainer, Ejector (See OIP-MS39086-81)
7269124	Retainer, Feed Cam
7269266	Retainer, Spring
7791597	Rod Assembly, Operating
7269333	Roller, Cartridge Feed
7790559	Screw, Machine, w/Lock Washer
7269209	Sear
7269276	Shaft, Barrel Locking
11010152	Shaft, Cartridge Guide
7790724	Shaft, Cartridge Pawl
7269239	Slide Assembly, Cocking Handle
7269303	Spring Driving
7269087	Spring, Firing Pin
7269085	Spring, Helical Compression (use with Ejector Plunger)
7269086	Spring, Helical Compression (use with Extractor Plunger)
7269105	Spring, Helical Compression (use with Buffer Assembly)
7269106	Spring, Helical Compression (use with Buffer Assembly)
7269107	Spring, Helical Compression (use with Buffer Assembly)
7269108	Spring, Helical Compression (use with Buffer Assembly)
7269125	Spring, Helical Compression (use with Feed Cam Retainer)
7269211	Spring, Helical Compression (use with Sear Plunger)
7269300	Spring, Helical Compression (use with Barrel Lock Lever)
7791522	Spring, Helical Compression (use with Cocking Handle)
7790551	Spring, Helical Compression (use with Magazine Bracket)
7269301	Spring, Helical Torsion (use with Cover Hinge)
7269335	Spring, Helical Torsion (use with Feed Tray)
7792398	Spring, Lock, Retainer Pin
7269035	Washer, Lock
7269344	Yoke, Buffer Retaining

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

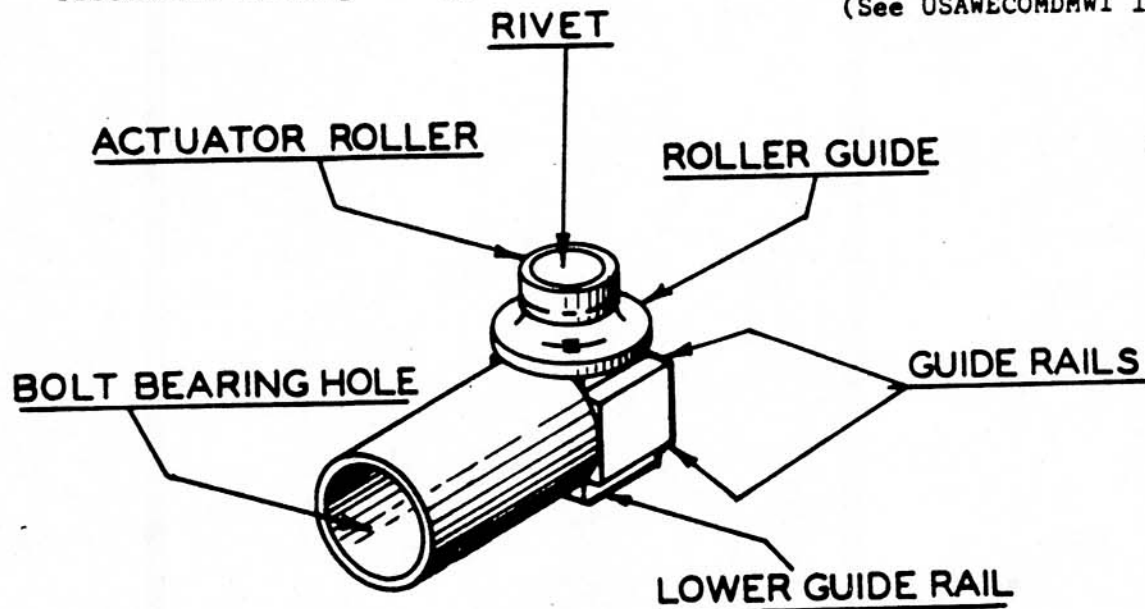
OIP-7269063
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Actuator Assembly, Cam
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

Important: Further disassembly is not required

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the roller, roller guide, bolt bearing hole and guide rails, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Improper Assembly (Roller and roller guide must rotate freely and shall be retained securely to actuator by the rivet)	0.65	Visual-Manual	
3. Missing or Defective Protective Coating	1.5	Visual	Solid Film Lubricant (See USAWECOMDMWI 1005-224)



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

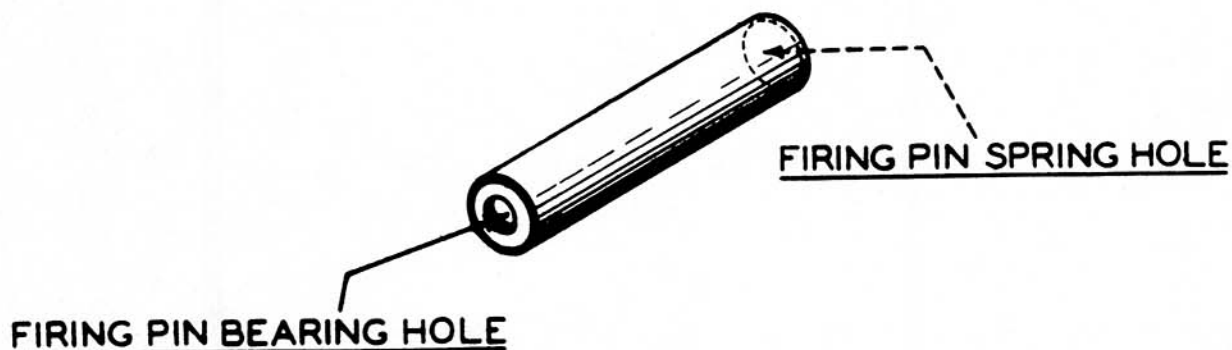
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269065
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Bearing, Firing Pin
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the firing pin bearing hole and spring hole as indicated in figure below for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

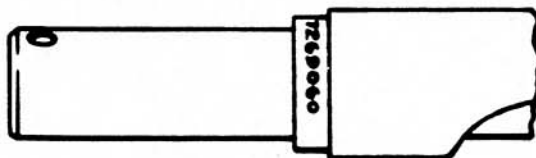
OIP-7269060
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Bolt
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

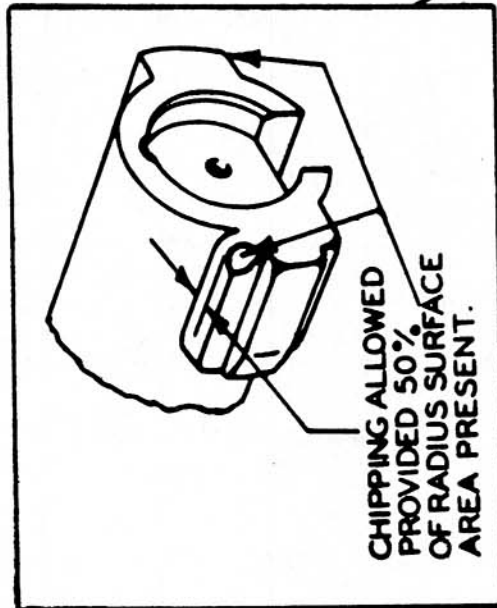
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the following areas, as indicated in the figure on page 2.)	0.65	Visual	
a. The locking surfaces of the locking lugs for cracks, burrs or mutilations.			
b. The camming surfaces of the locking lugs to assure that chipping does not exceed that depicted in figures on page 2.			
c. The front edge of the extractor retaining recess for chipping or burrs.			
d. The edge of the cam for chipping, mutilations or burrs.			
2. Diameter Firing Pin Hole (See figure on page 3)	0.65	7458598	Not Go .108
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

NOTE: Only bolts (8620H) with part number stamped on diameter as shown in figure below and meeting the criteria specified herein will be considered acceptable. All other bolts (8620) meeting the acceptance criteria specified will be held for disposition instructions from AMSWE-SMM.

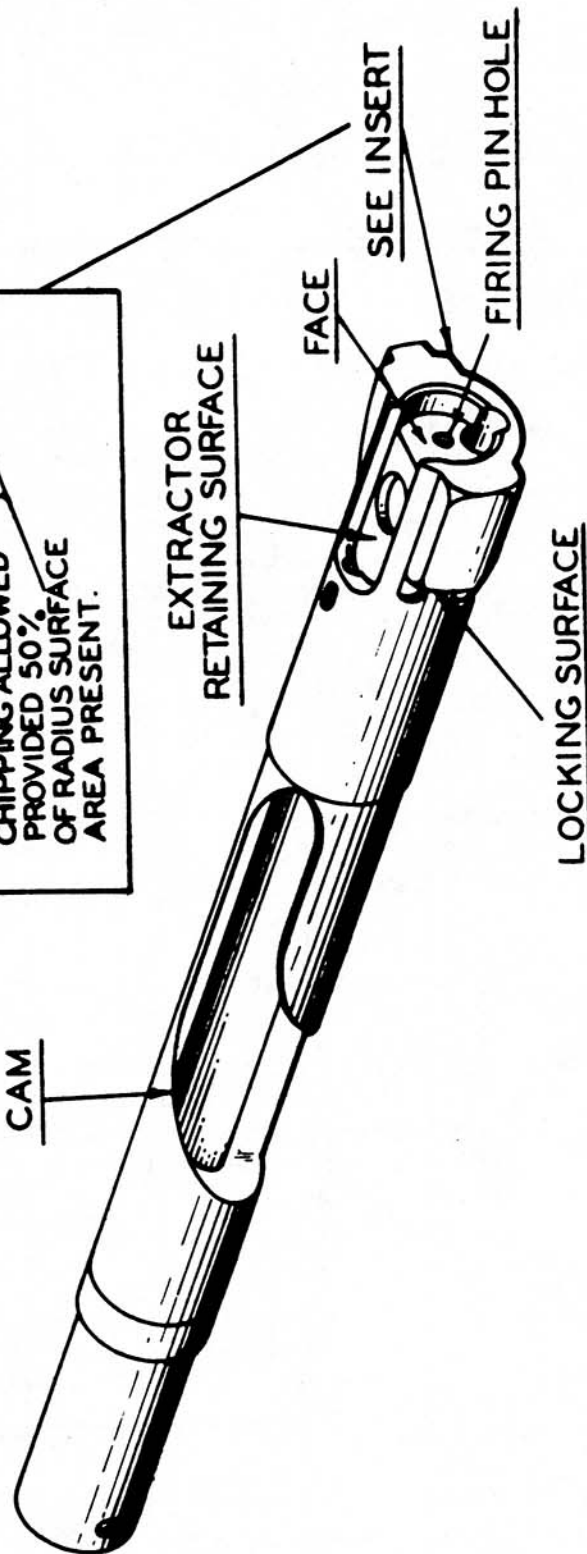


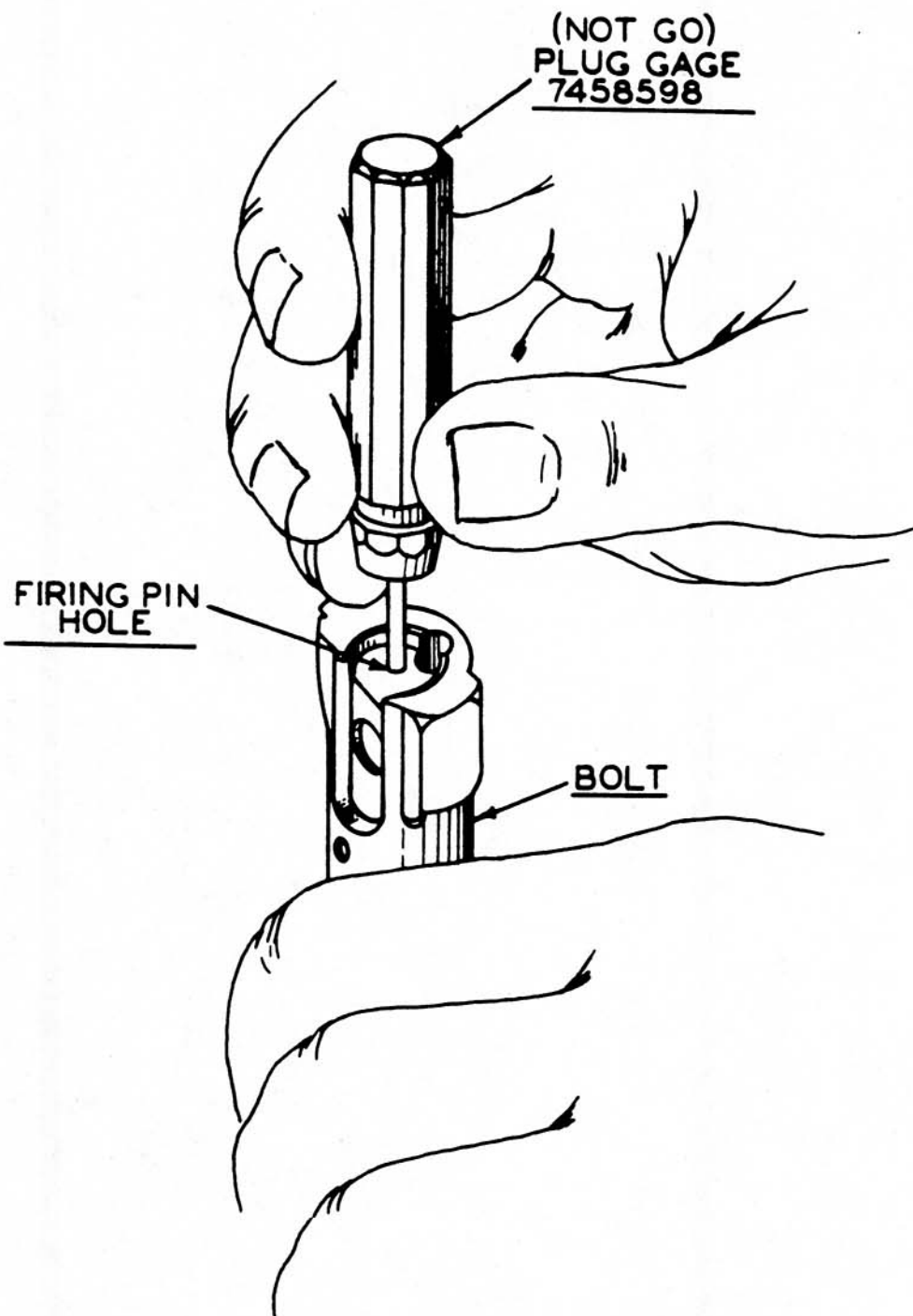
*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

CHIPPING ALLOWANCE
FOR BOLTS TO BE USED
IN M60 APPLICATIONS
ONLY. THERE SHALL BE
NO CHIPPING PERMITTED
ON BOLTS FOR M60C
APPLICATIONS.



CAM





U.S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269097
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Cap, Buffer
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the pin hole as indicated in figure below for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

PIN HOLE



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-11010292
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

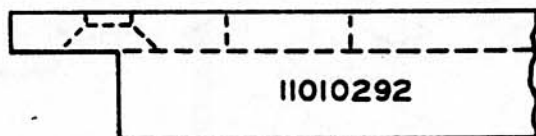
Item: Channel Assembly, Feed Cam
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the channel and cam return spring, as indicated in figure on page 2, for cracks, burrs or mutilations.)	0.65	Visual	
2. Improper Assembly Examine for completeness of assembly, (see figure on page 2) and check secureness of components. Roller shall rotate freely, and cam return spring upon deflection, shall return to original position.	0.65	Visual-Manual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

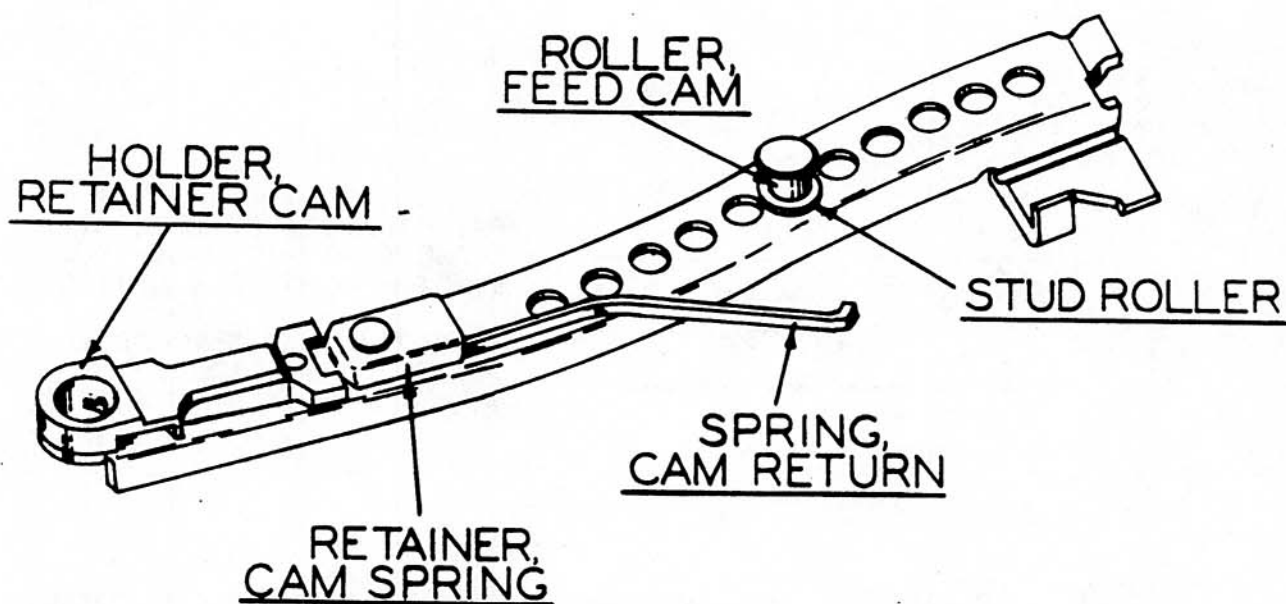
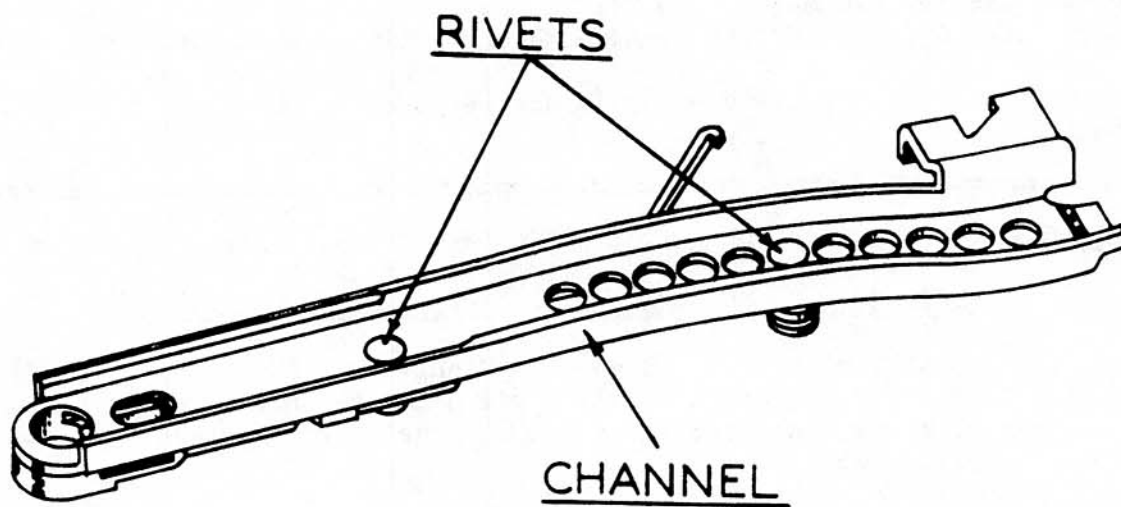
NOTE: Both design types specified in figure below are acceptable for applications indicated.



PART NUMBER 11010292 WITH
NUMBER AS SHOWN TO BE USED
FOR M60 AND M60C APPLICATIONS.

PART NUMBER 7269122 WITHOUT
NUMBER TO BE USED FOR M60
APPLICATIONS ONLY.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

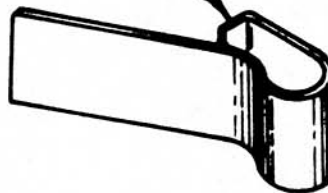
OIP-7269146
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Clip, Spring, Lever
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the retaining lip as indicated in figure below for burrs, cracks, and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Black Oxide

RETAINING LIP



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

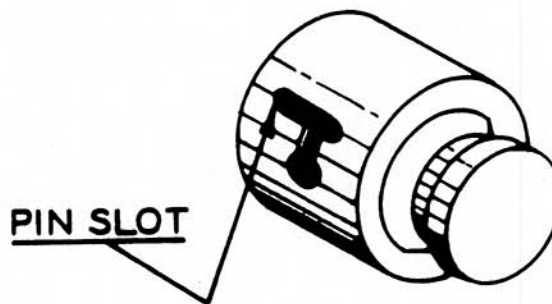
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269098
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Cover, Buffer
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pin slot area as indicated in figure below for burrs, cracks, or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



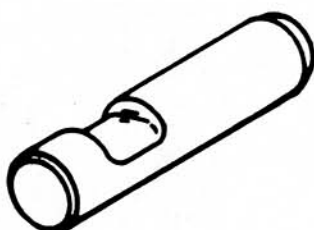
*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

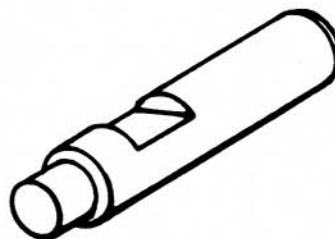
OIP-11010375
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Ejector
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.



EJECTOR
11010357



EJECTOR
7269073

All ejectors shall be replaced by new ejectors in overhauled weapons. No ejectors will be reused and no ejectors (7269073) will be used.

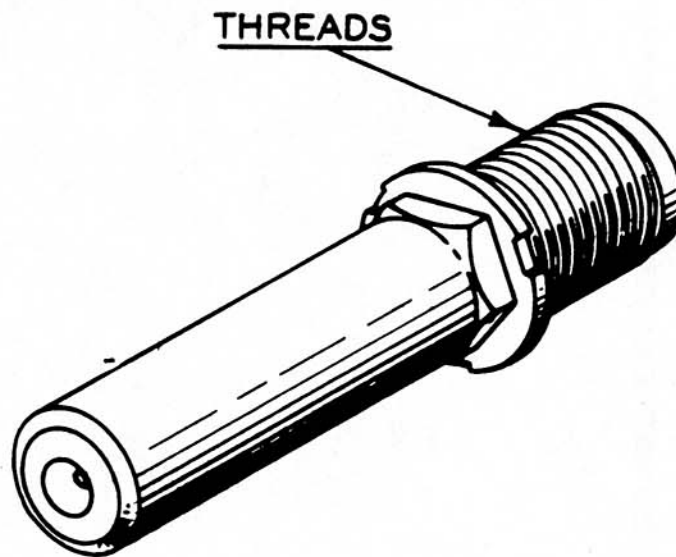
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269030
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Extension, Gas Cylinder
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the threads as indicated in figure below for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Black Oxide Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

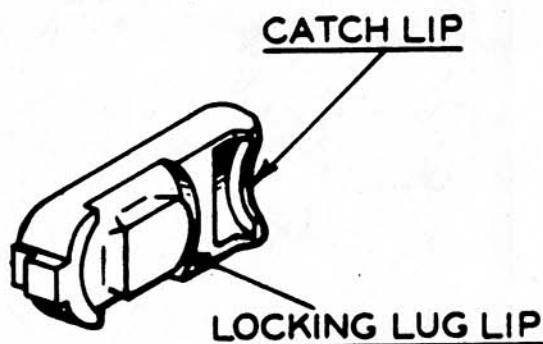
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7790907
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

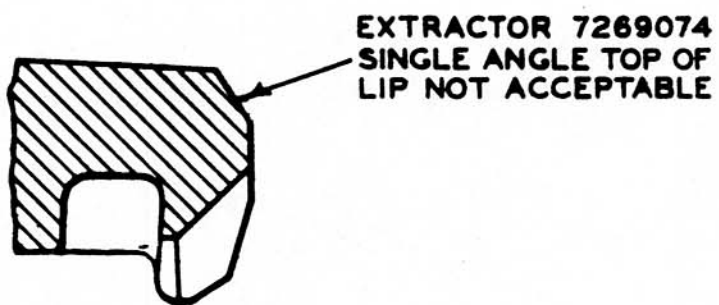
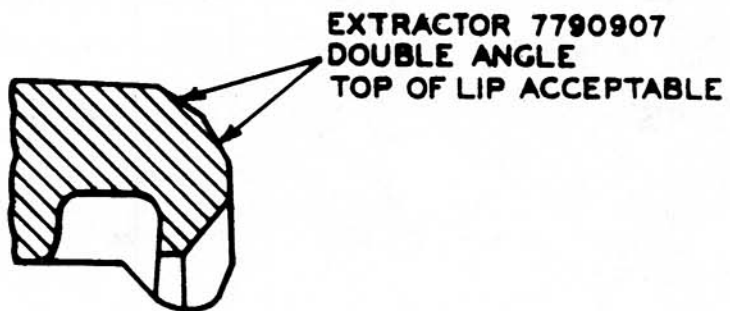
Item: Extractor
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the catch lip and locking lug lip as indicated in figure below, for burrs, chips, or mutilations.)	0.65	Visual	
2. Design Type (See figure on Page 2 for acceptable design.)	0.65	Visual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7792097
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

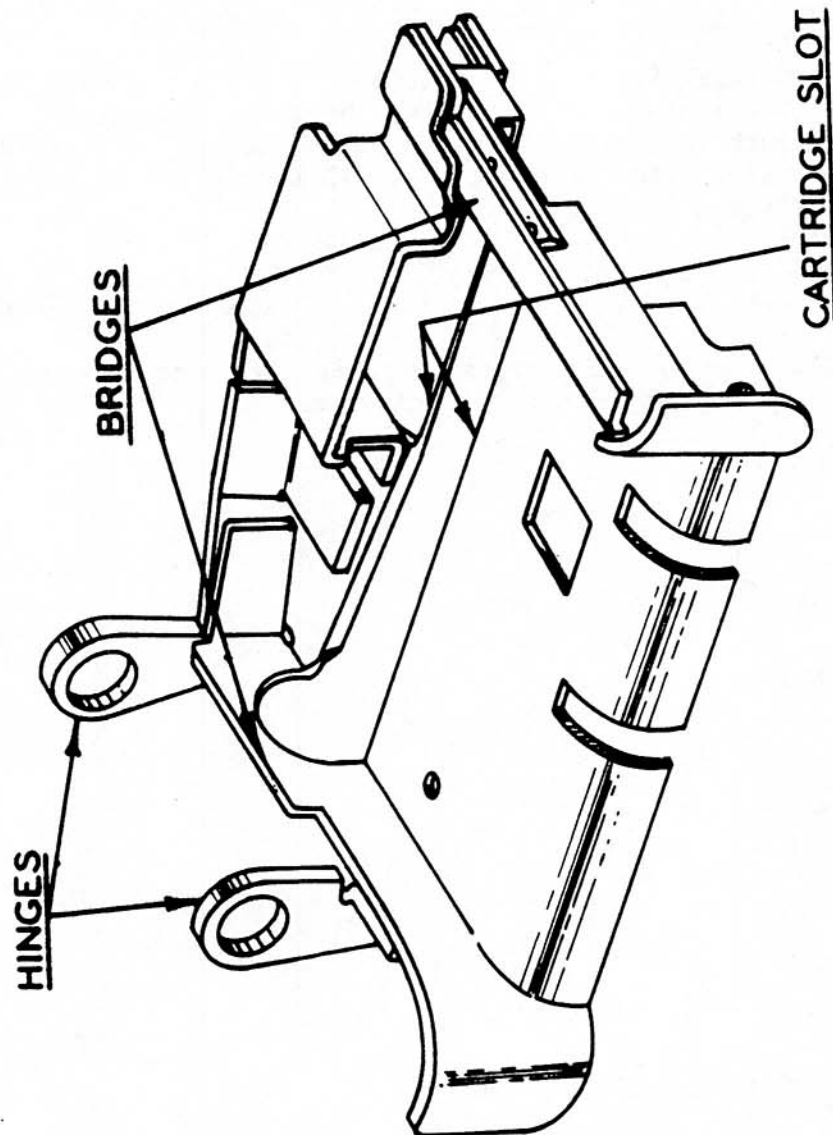
Item: Frame Assembly, Cartridge Tray
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

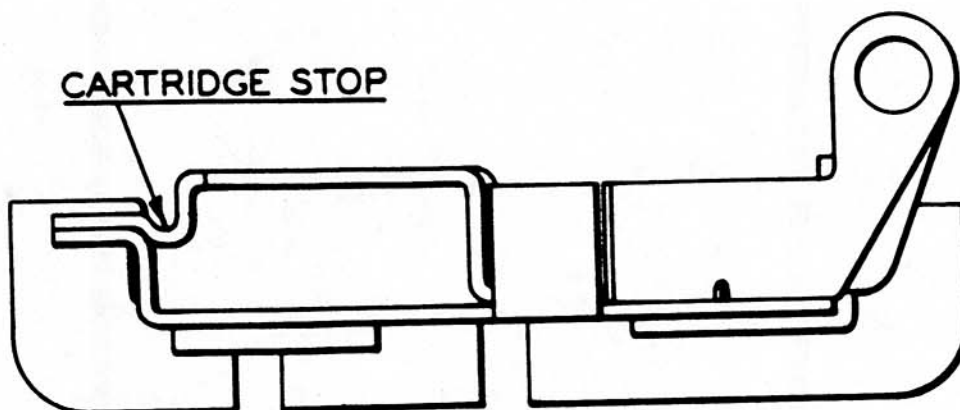
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the bridge, hinge, and cartridge slot areas for burrs, cracks, or mutilations. Manually examine for secureness of all spotwelded and riveted parts. See figure on page 2.)	0.65	Visual-Manual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

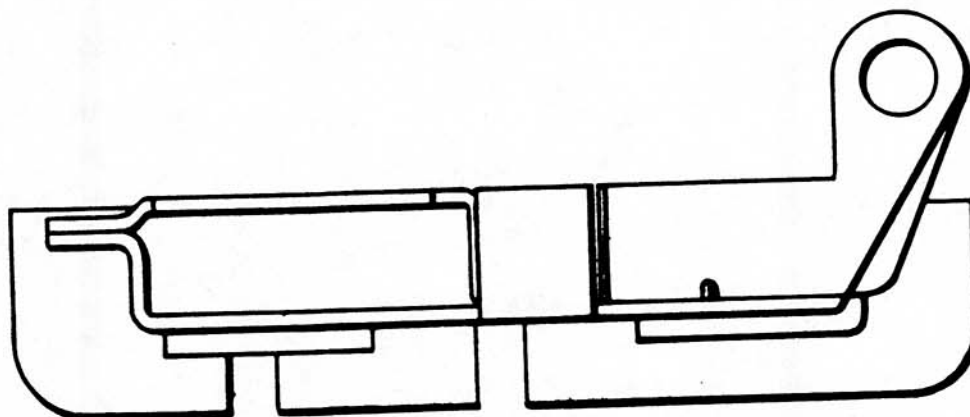
NOTE: Both design types shown in figure on page 3 are acceptable
for applications indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.





**FRAME ASSEMBLY CARTRIDGE TRAY 7792097
(WITH CARTRIDGE STOP)
FOR M60 AND M60C APPLICATIONS**



**FRAME ASSEMBLY CARTRIDGE TRAY 7269331
(WITHOUT CARTRIDGE STOP)
FOR M60 APPLICATIONS ONLY**

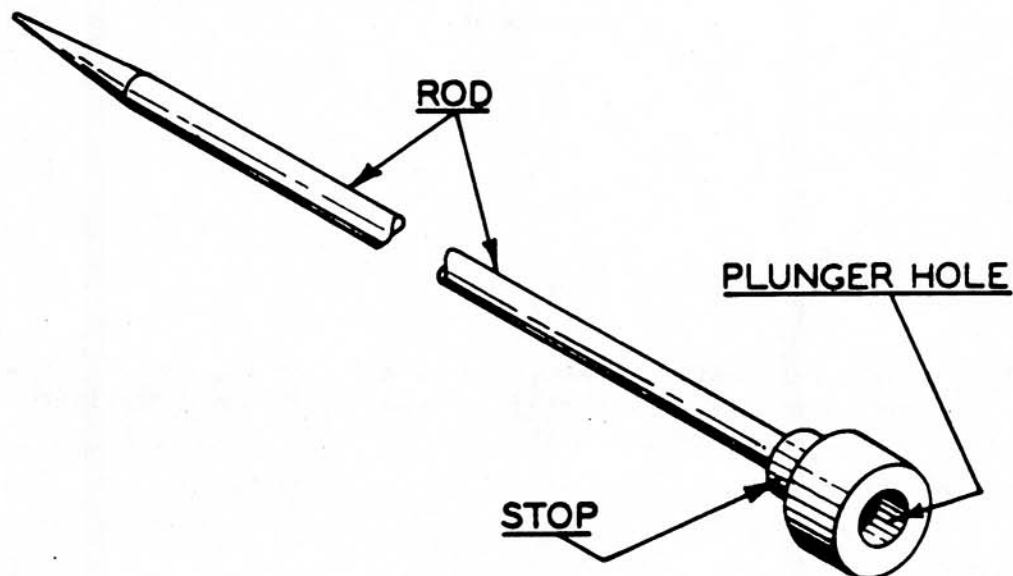
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269199
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Guide Assembly
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

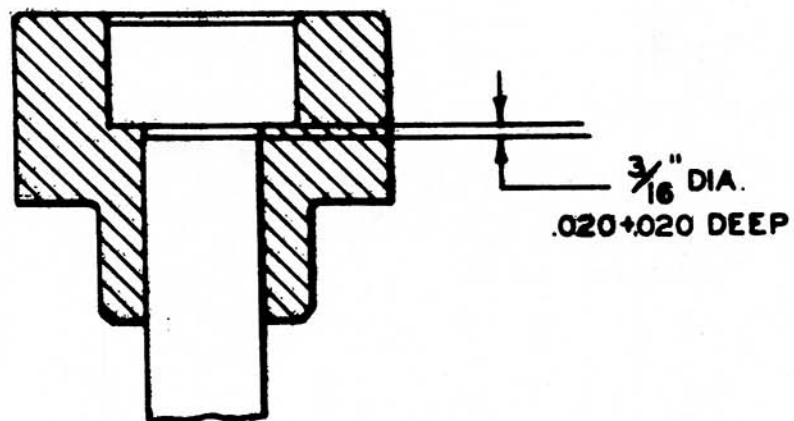
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the plunger hole for burrs and mutilations. Manually examine for secureness of rod to stop. See Figure below.)	0.65	Visual-Manual	
2. Intrusion, Rod in Head, Under (See figure on page 2 for modification.)	0.65	Visual	.020 Min.
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



PROCESS INSPECTION. See page 2 for required reconditioning.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.



NOTE: The Government representative shall conduct surveillance of the supplier's reconditioning process, to assure compliance with requirements depicted above.

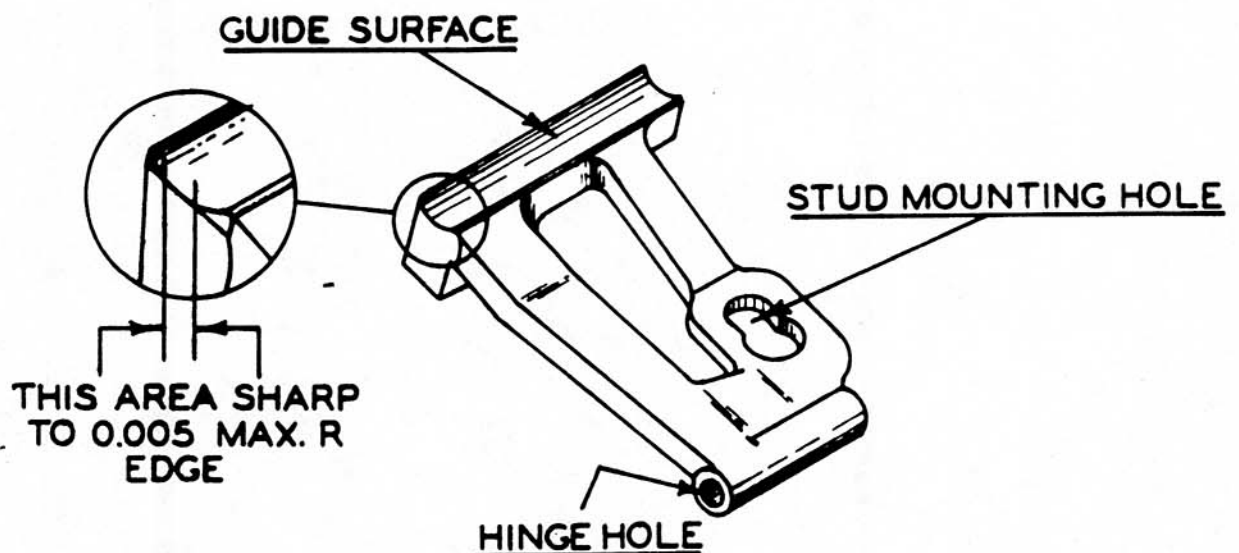
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269116
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Guide, Cartridge, Front
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the stud mounting hole, guide surface, and hinge hole as indicated in figure below for burrs or mutilations.)	0.65	Visual	
2. Edge, Stripping Corner	0.65	Visual (See figure below)	.005 Max
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

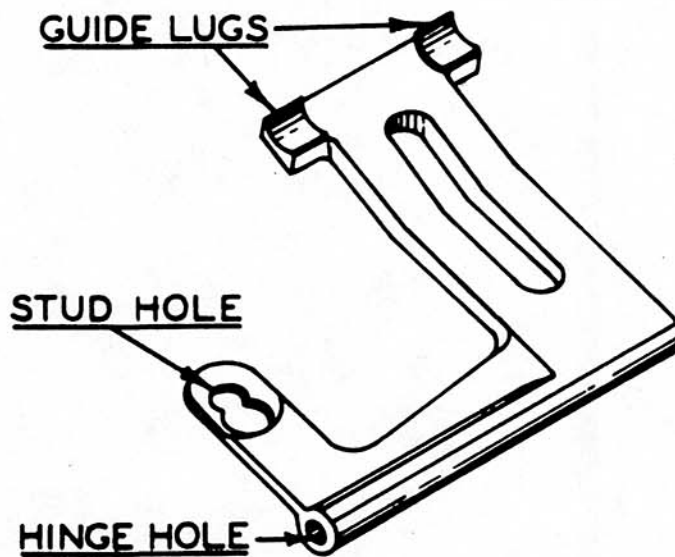
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269117
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Guide, Cartridge, Rear
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the stud hole, hinge hole and guide lug, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

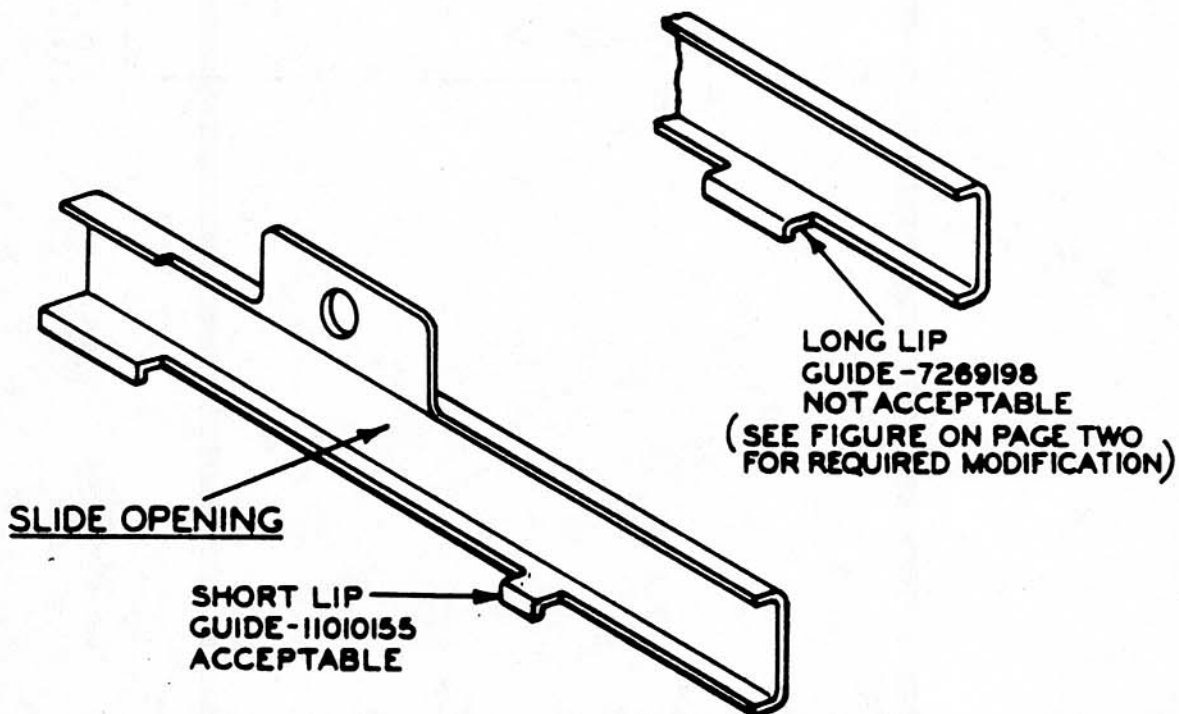
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-11010155
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Guide, Cocking Handle
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

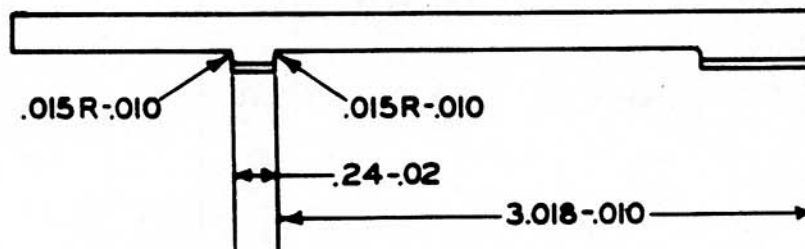
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the slide opening, as indicated in figure below, for dents or mutilations.)	0.65	Visual	
2. Design Type (See figure below for acceptable type.)	0.65	Visual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



PROCESS INSPECTION. See page 2 for required modification.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

BOTTOM VIEW



NOTE: The Government representative shall conduct surveillance of the suppliers reconditioning operation for rejected components on Defect 2, to assure compliance with requirements depicted above.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269099
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

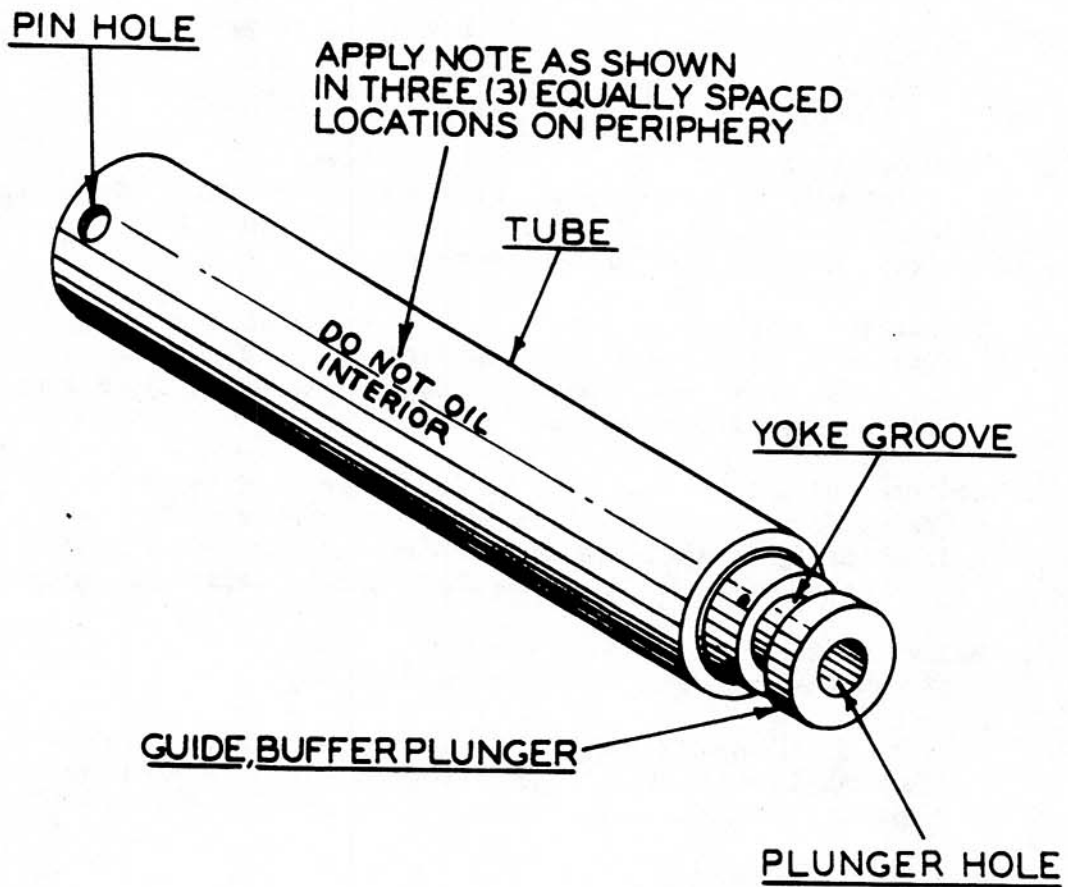
Item: Housing Assembly, Buffer
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

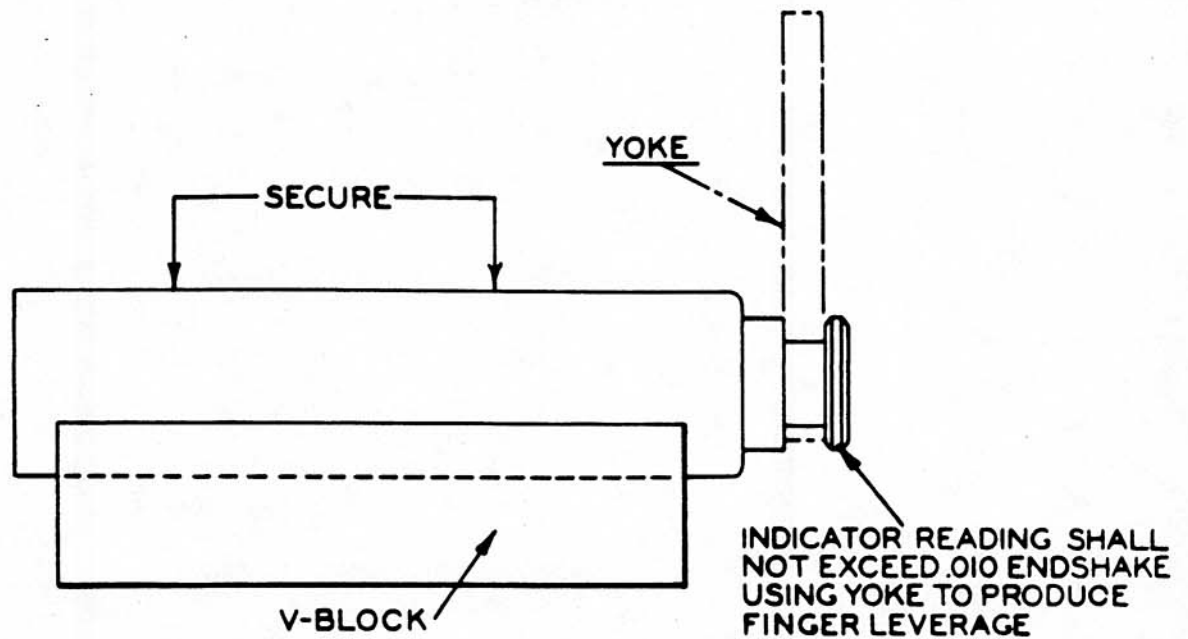
Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

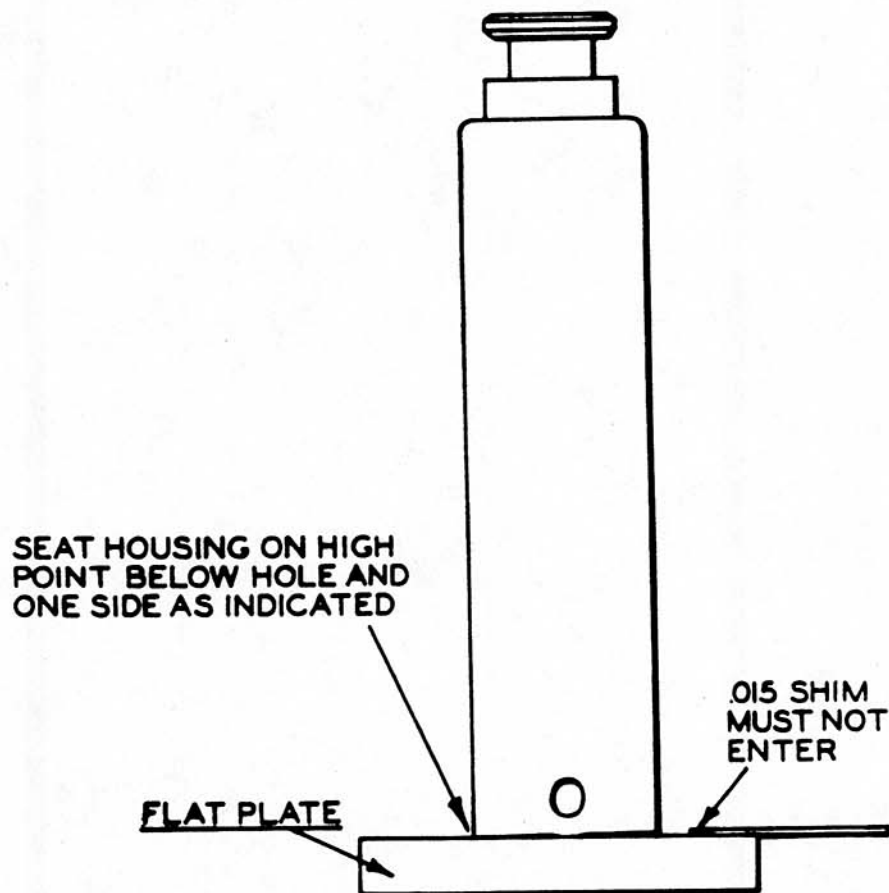
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the tube, pin hole, plunger hole, yoke groove and guide, as indicated in figure on page 2, for burrs, deformations or mutilations.)	0.65	Visual	
2. Elongation of Pin Hole (Visual examination will be used for elongation check. Where doubt exists as to acceptance of component, measurement shall be made as indicated in figure on page 3.)	0.65	Visual-Measure	
3. Endshake of Guide (Manual examination will be used for endshake of guide. If endshake is evident, it shall be measured as indicated in figure on page 3. Rotational movement of guide shall not be cause for rejection.)	0.65	Manual-Measure	
4. Defective Epoxy Sealer (Epoxy shall show no evidence of breaks.)	0.65	Visual	
5. Missing or Illegible Marking (Tube shall be marked "DO NOT OIL INTERIOR" in three places. For remarking procedure see Section 6 of USAWECOMDMWI 1005-224.)	0.65	Visual	See Figure on Page 2
6. Missing or Defective Protective Coating (Spray guide only, do not apply to plunger hole. Interior shall be free of oil.)	1.5	Visual	Spray Paint (See USAWECOMDMWI 1005-224)

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.





ENDSHAKE INSPECTION METHOD



ELONGATION INSPECTION METHOD

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269118
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Housing Assembly, Cover
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

Important: Further disassembly is not required.

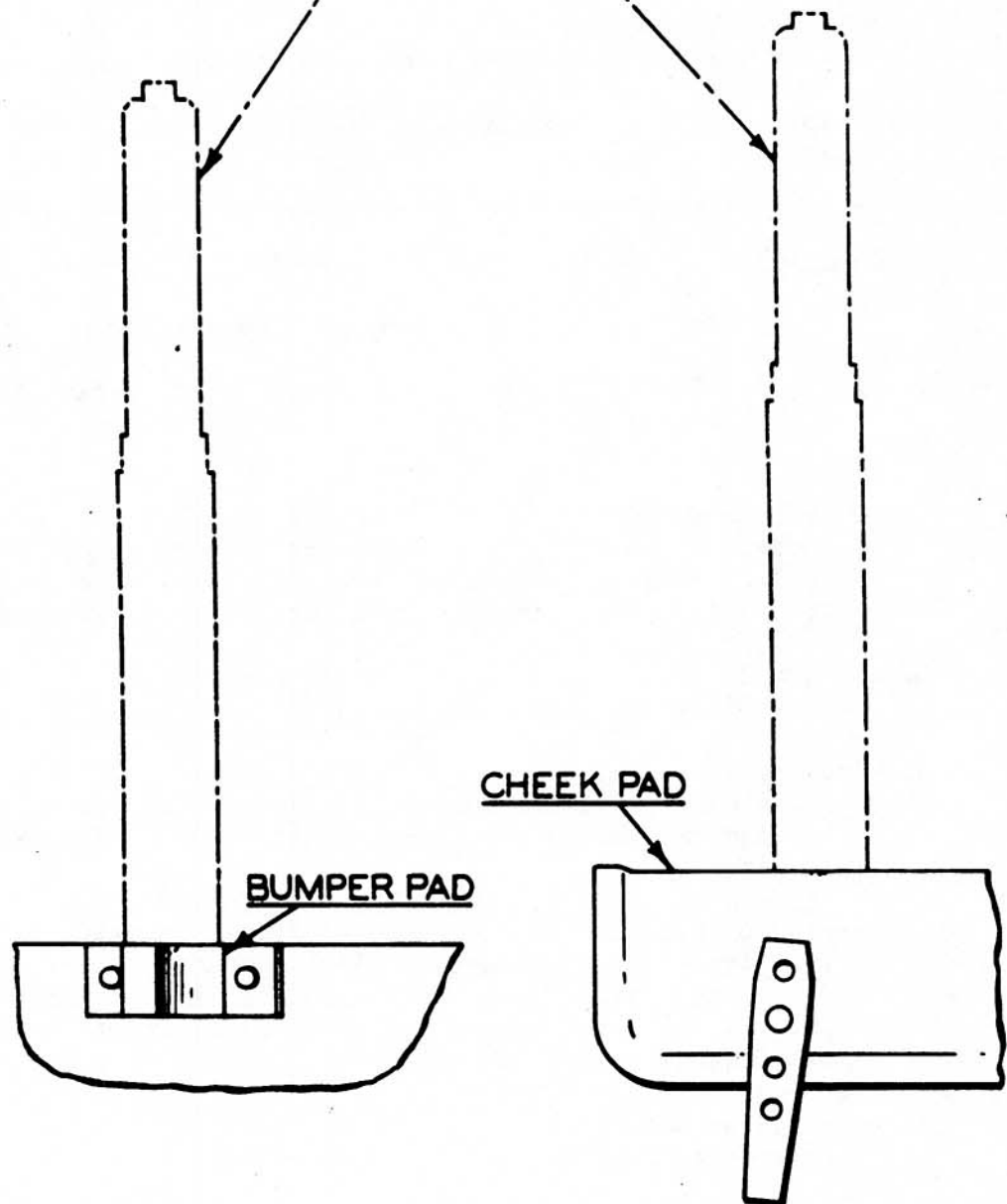
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Hardness, Rubber Coating (See figures on pages 2 and 3)	0.65	Hardness Tester	45 Min.
2. Defective Rubber (Rubber of cheek pad and bumper pad shall be free of tears and breaks. Surface mars not exceeding 1/32 inch in depth and one inch in length are acceptable. Other surface scratches or scuffing are acceptable.)	0.65	Visual	
3. Design Type (See figure on page 4 for acceptable type)	0.65	Visual	
4. Serviceability (Particular attention shall be given to the latch, shield, studs, springs, and hinge for burrs, mutilations or distortion. See figure on page 5.)	0.65	Visual	
5. Improper Assembly (The latch lever assembly shall be securely retained and rotate freely and shall return to original position under spring tension. Riveted or brazed components shall be secure as determined manually. See figure on page 5.)	0.65	Visual-Manual	
6. Missing or Defective Protective Coating	1.5	Visual	Spray Paint (See USAWECOMDMWI 1005-224)

PROCESS INSPECTION. See page 6 for required modifications.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

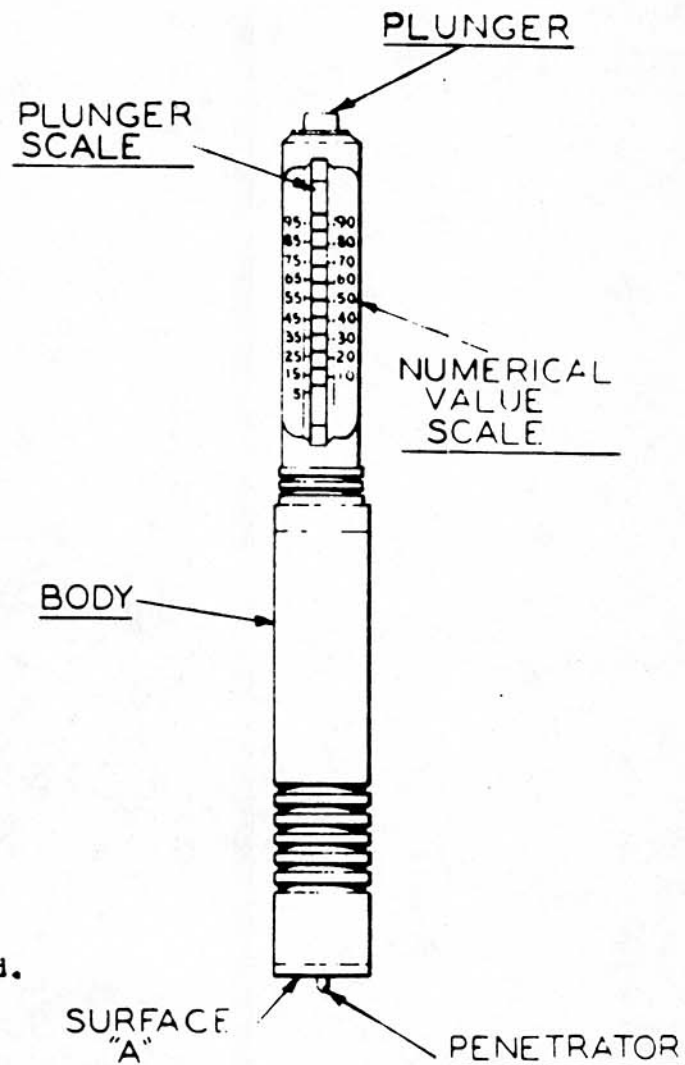
SEE NEXT PAGE FOR INSTRUCTIONS
FOR USE OF TESTER



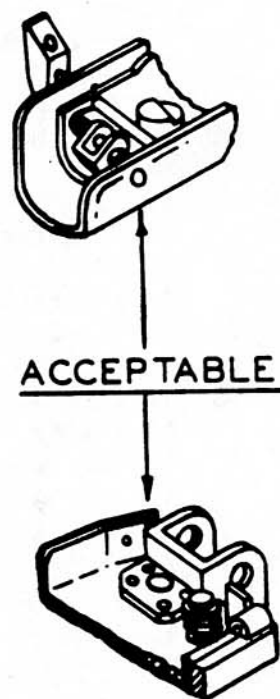
HARDNESS VALUE SHALL BE THE
AVERAGE OF THREE (3) READINGS

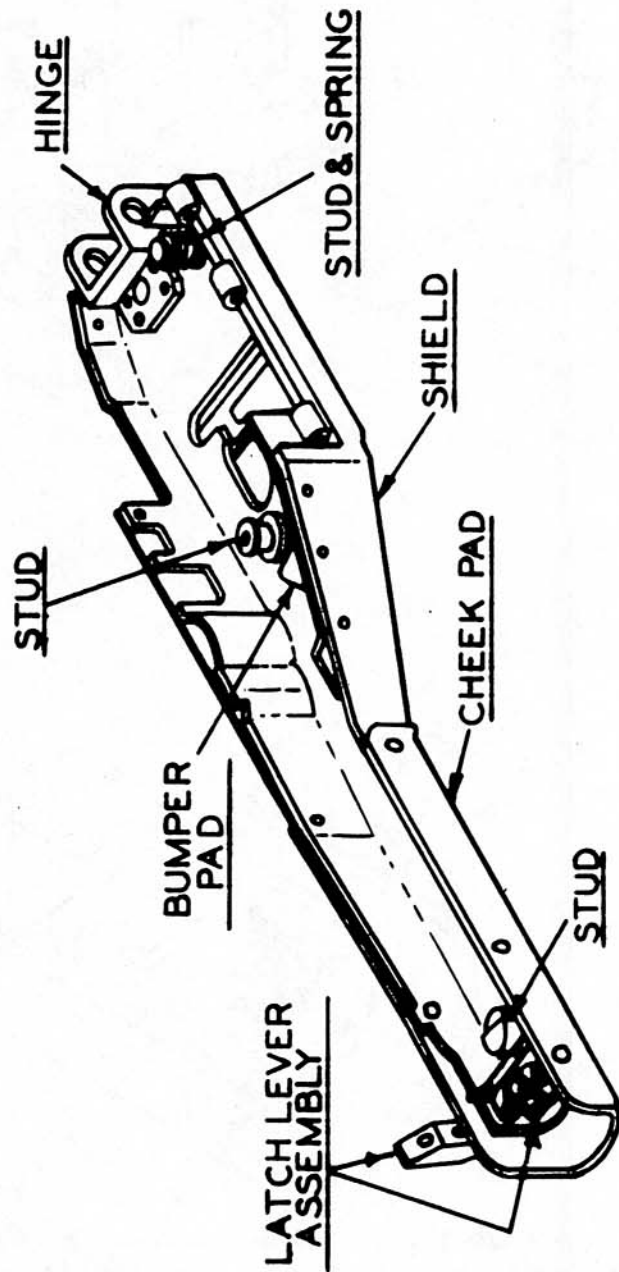
TEST INSTRUCTIONS

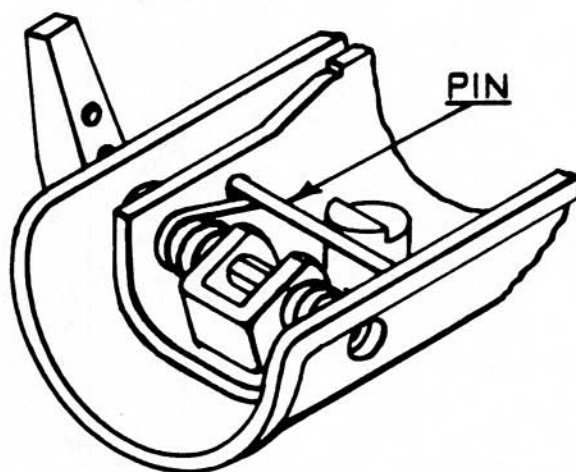
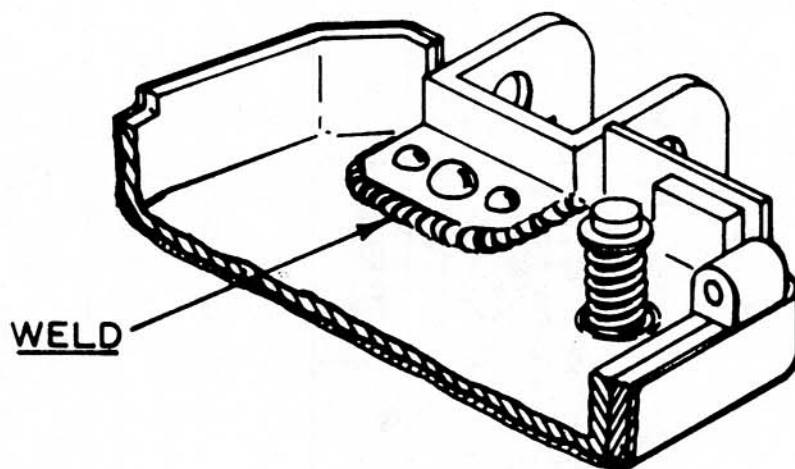
1. Prior to testing, assure that plunger is depressed.
2. Place penetrator on test piece, holding body perpendicular to test surface.
3. Holding body, depress hardness tester until surface "A" is flush with test surface.
4. Remove tester from piece and read hardness value.
5. Value shall be that number appearing where lines on numerical value scale and plunger scale are aligned.



Testing Machine Inc.
Mineola, New York
Rex Hardness Gauge
Model 1500
(Or approved equal)







NOTE: The Government representative shall conduct surveillance of the supplier's reconditioning operation for rejected components on Defect 3 to assure compliance with requirements depicted above.

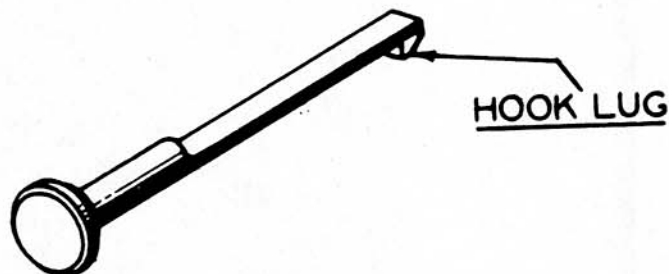
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269243
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Latch, Hinge Pin
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given hook lug, as indicated in figure below, for burrs and deformations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

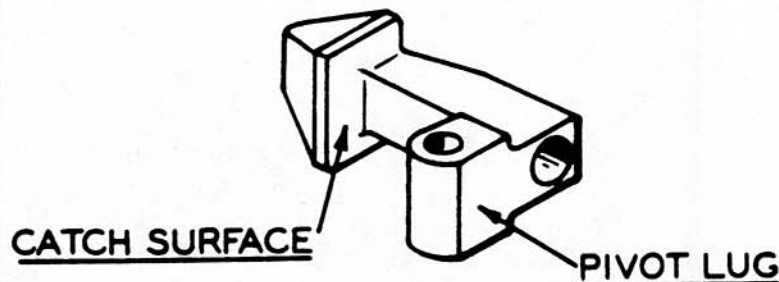
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7790553
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Latch, Magazine
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the catch surface and pivot lug, as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

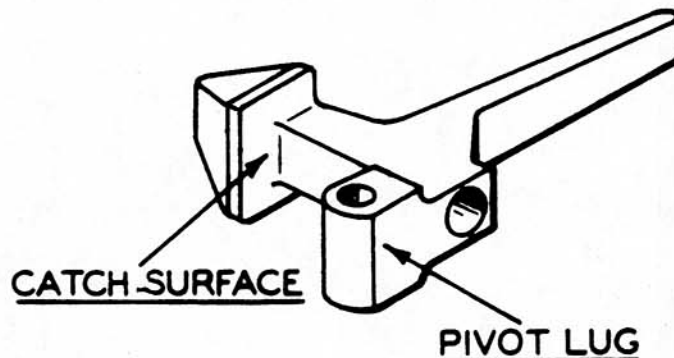
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7790554
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Latch, Magazine Release
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the catch surface and pivot lug, as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

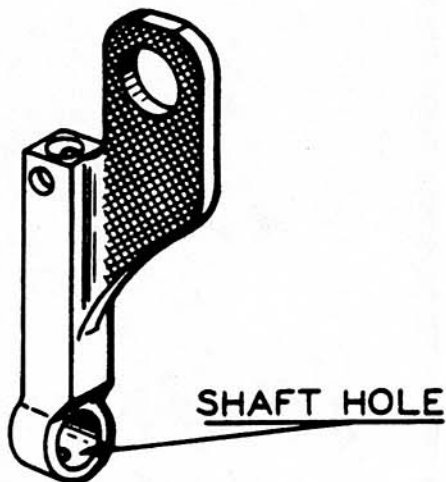
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269244
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Lever, Barrel Lock
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the shaft hole area, as indicated in figure below, for burrs, cracks, or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

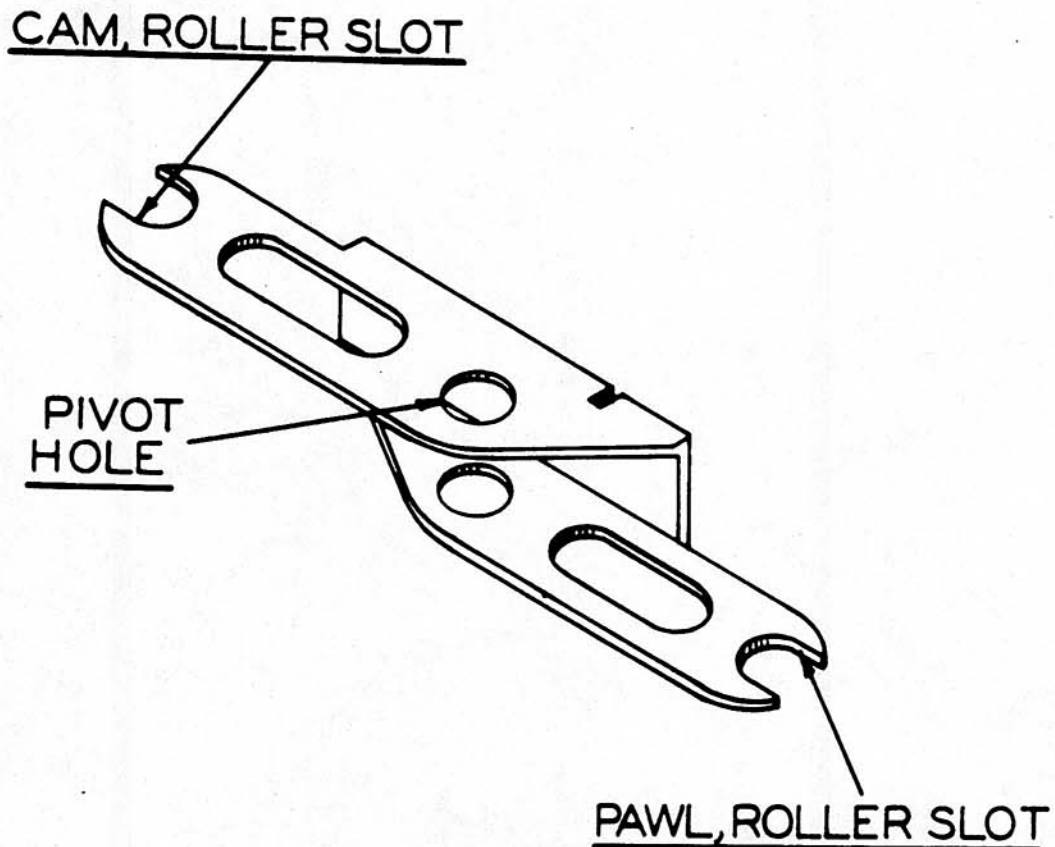
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269145
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Lever, Feed
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the roller slots and pivot hole, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269031
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Nut, Gas Cylinder
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the threads and tube bearing, as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Black Oxide

THREADS



TUBE BEARING

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269120
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

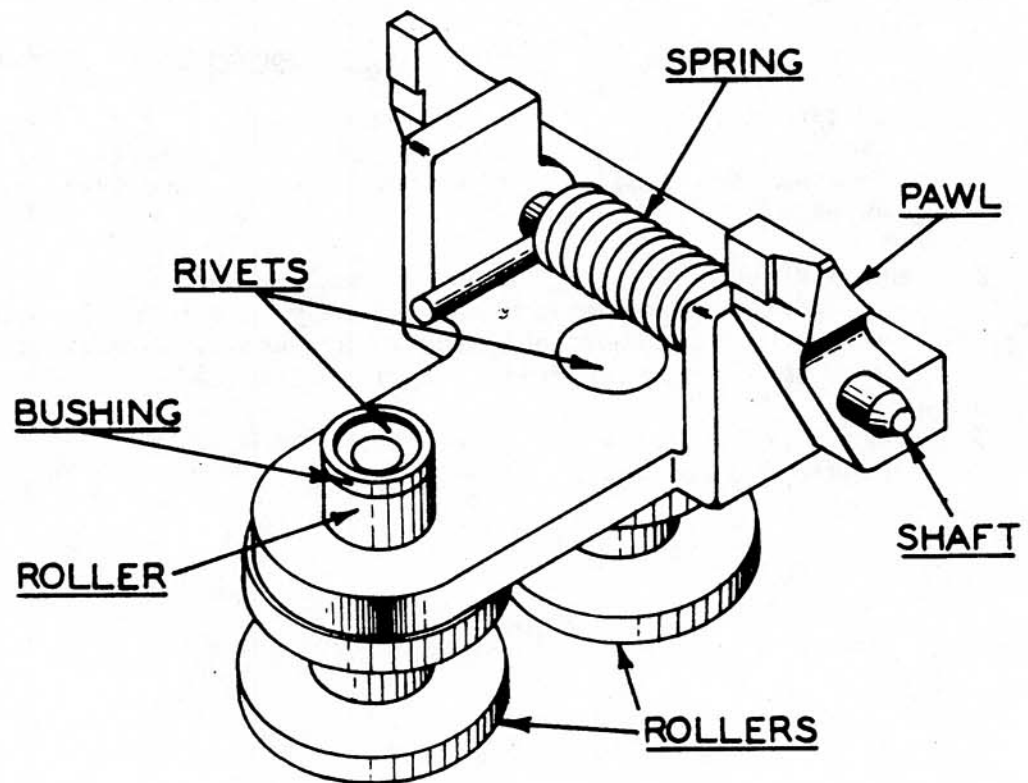
Item: Pawl Assembly, Feed
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the spring for breaks or deformations, and to the pawl for burrs or mutilations. See figure on page 2.)	0.65	Visual	
2. Improper Assembly (Examine for completeness of assembly, shaft, pawl, spring, rollers and bushing. Rivets shall be secure and rollers shall turn freely. Pawl shall function freely under spring load. See figure on page 2.)	0.65	Visual-Manual	
3. Missing or Defective Protective Coating	1.5	Visual	Solid Film Lubricant (See USAWECOMDMWI 1005-224)

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

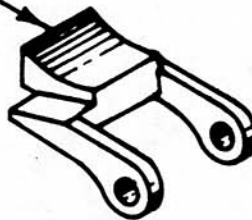
OIP-7269332
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pawl, Cartridge Retainer
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the retaining edge, as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

RETAINING EDGE



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-11010181
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Cotter
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.



PIN-11010181
USE WITH
SHAFT-11010152
AND PIN-7792069



CLIP, RETAINING
A 7790555
ECAX I.I

All cotter pins will be replaced in overhauled weapons for use as indicated in figure above. No cotter pins will be reused and no retaining clips shall be used.

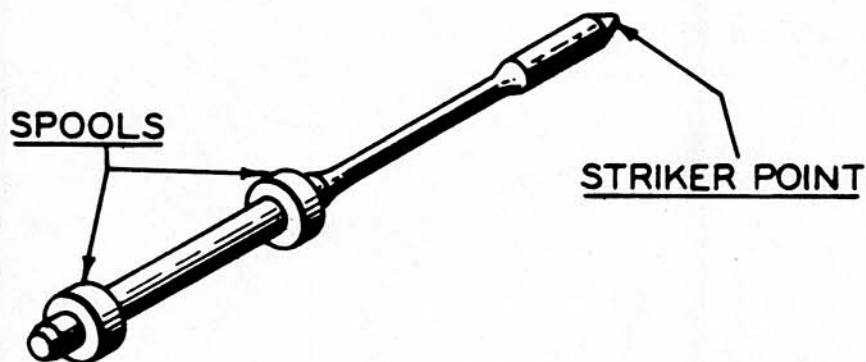
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269081
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Firing
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability	0.65	Visual	
(Particular attention shall be given the fillet radii from spools to body for cracks or circumferential marks worn in radii, and striker point for pits or erosion. See figure below.)			



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

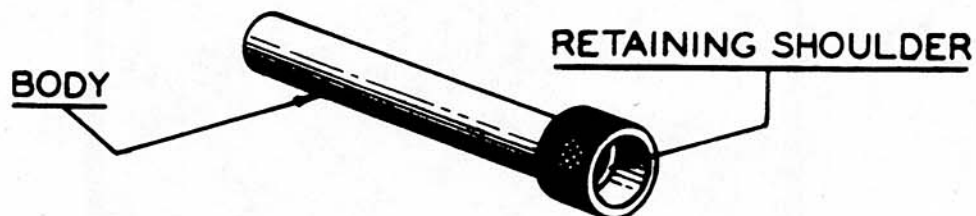
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269247
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Hinge, Cover
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defects</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the body and retaining shoulder, as indicated in the figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

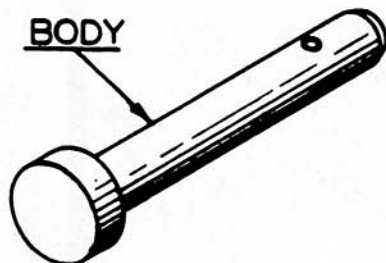
OIP-7792069
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Latch
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

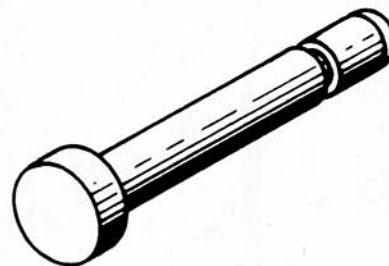
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Design Type (See Figure below for acceptable type)	0.65	Visual	
2. Serviceability (Particular attention shall be given body, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

ACCEPTABLE
7792069



NOT ACCEPTABLE
7790552



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

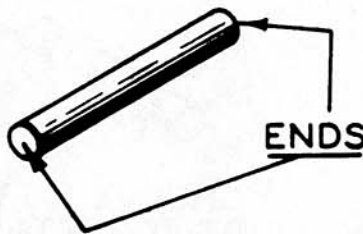
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7792920
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Lock
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

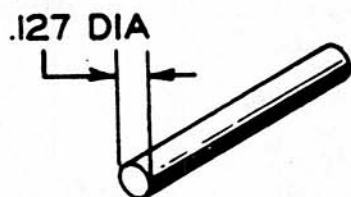
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Design Type (See figure on page 2 for acceptable type)	0.65	Visual	
2. Serviceability (Particular attention shall be given to ends, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



Bot 5/1/65

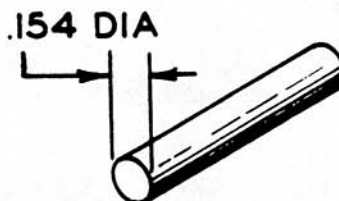
*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

ACCEPTABLE
(PIN # 7792920)



USE WITH
PLUG 7791600
FOR M60 AND M60C
APPLICATIONS

ACCEPTABLE
(PIN # 7269080)



USE WITH
PLUG 7269092
FOR M60 APPLICATIONS
ONLY



GROOVED TYPE
NOT ACCEPTABLE

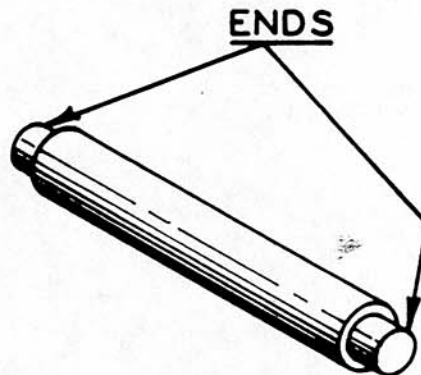
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269101
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Lock, Cover
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given ends, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

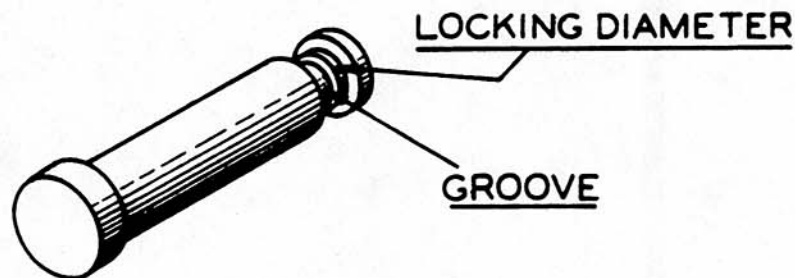
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269205
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Retaining
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the groove and lock diameter, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



Trigger Pin

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269248
Approved: 28 May '65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Spring Retainer
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the body, as indicated in figure below, for burrs and deformations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

BODY



Barrel 8-12

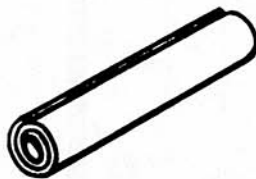
*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

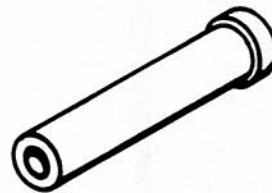
OIP-MS39086-81
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Spring, Tubular, Coiled
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.



PIN, SPRING
MS 39086-81



RETAINER, EJECTOR
7269084

Ejector retainers and spring pins shall be replaced by new spring pins in all overhauled weapons for retention of ejectors. No pins will be reused and no ejector retainers (7269084) will be used.

Not used

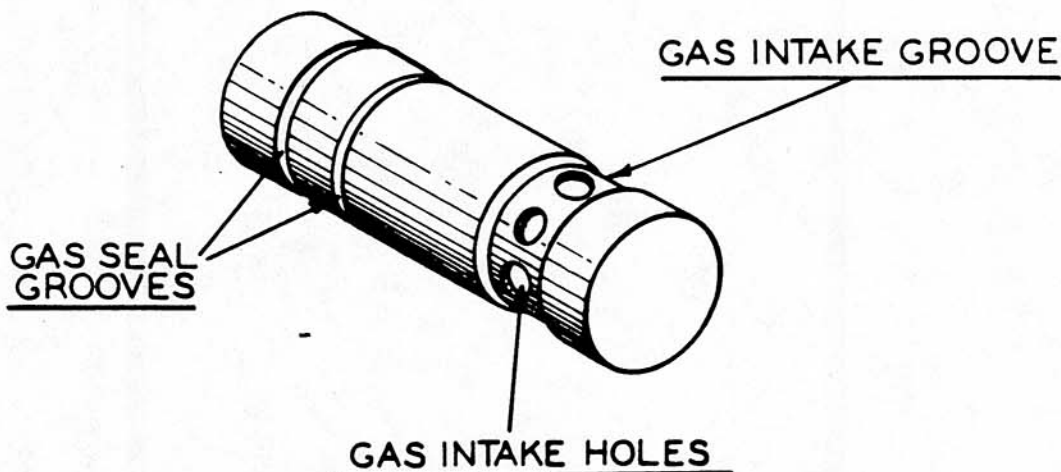
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7791247
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Piston, Gas
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the gas intake holes and groove and the gas seal grooves, as indicated in the figure below, for burrs, cracks, or mutilations.)	0.65	Visual	
2. Missing or Defective Chrome Plating (Carbon discoloration of chrome not removeable by normal cleaning operations is permissible.)	0.65	Visual	



*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7791600
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plug, Bolt
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the retaining pin hole and thread areas as indicated in figure below, for burrs, cracks or mutilations. Slight chipping around pin hole is acceptable.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	

NOTE: Both design types shown in figure on page 2 are acceptable for applications indicated.

RETAINING PIN HOLE



THREADS

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

**PLUG 7791600
USE WITH PIN 7792920**



**FOR M60 AND M60C
APPLICATIONS**

**PLUG 7269092
USE WITH PIN 7269080**



**FOR M60 APPLICATIONS
ONLY**

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

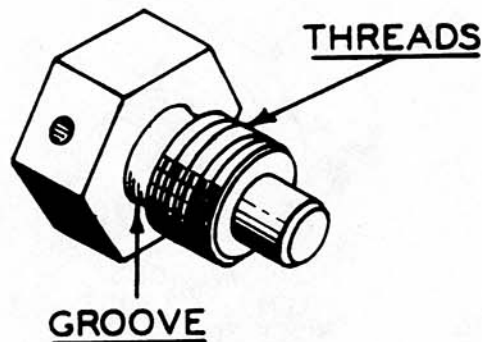
OIP-7792093
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plug, Gas Cylinder
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

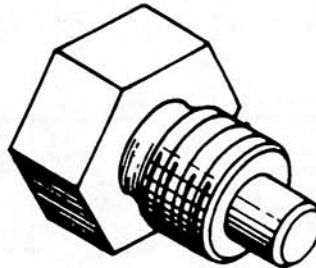
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the threads for burrs or mutilations, and to groove between head and thread for cracks. See Figure below.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

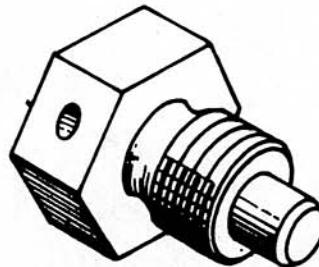
NOTE: Both designs shown in figure on Page 2 are acceptable for applications indicated.



*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



**PLUG 7790454
WITHOUT LOCK
WIRE HOLE FOR
M60 APPLICATION
ONLY**



**PLUG 7793093
WITH LOCK WIRE
HOLE FOR M60
AND M60C
APPLICATIONS**

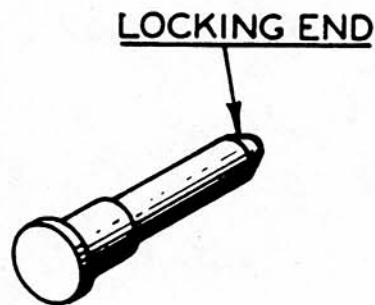
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269249
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plunger, Barrel Lock
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the locking end, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

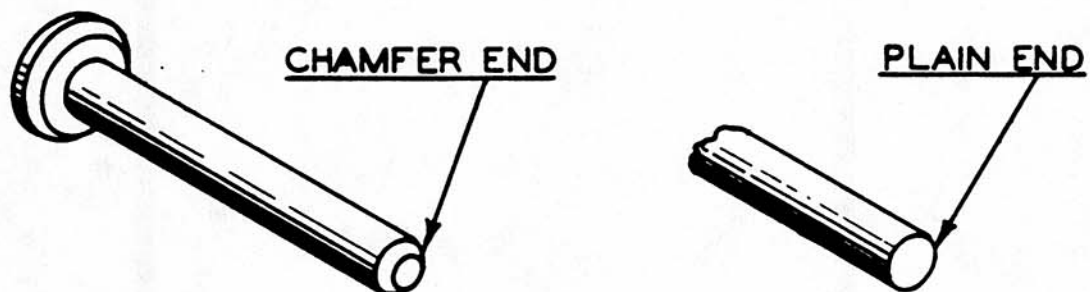
OIP-7269103
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plunger, Buffer
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the guide rod end, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

NOTE: Both types shown in figure below are acceptable



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269083
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plunger, Extractor
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the hole and notch, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269123
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plunger, Retainer
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the spring locking end, as as indicated in the figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269207
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plunger, Sear
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the sear contact, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269251
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Receiver Assembly
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

Important: Further disassembly is not required

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the barrel hole, yoke slot, and rails for burrs or mutilations; the tabs and spring of the magazine bracket for cracks or breaks; and the mounting plate for breaks or mutilations. See figure on page 3.)	0.65	Visual-Manual	
2. Improper Assembly (Secure receiver in vice at front lower position below barrel hole and manually examine secureness of assembly as follows. See figure on page 3.)	0.65	Visual-Manual	
a. Check for secure riveting of magazine bracket to receiver and for secureness of spring to magazine bracket.			
b. Check for secure riveting of mounting plate.			
c. Check for secureness of mounting pin.			
d. Check for secureness of all rivets in receiver assembly.			
3. Improper Modification (Channel shall be welded to receiver in trigger mechanism locking lug area. See figure on page 4.)	0.65	Visual	
4. Improper Modification (Examine for presence of letter R next to serial number as shown in lower figure on page 5. Absence of letter R indicates ramp angle requires modification as indicated in upper figure on page 5.)	0.65	Visual	

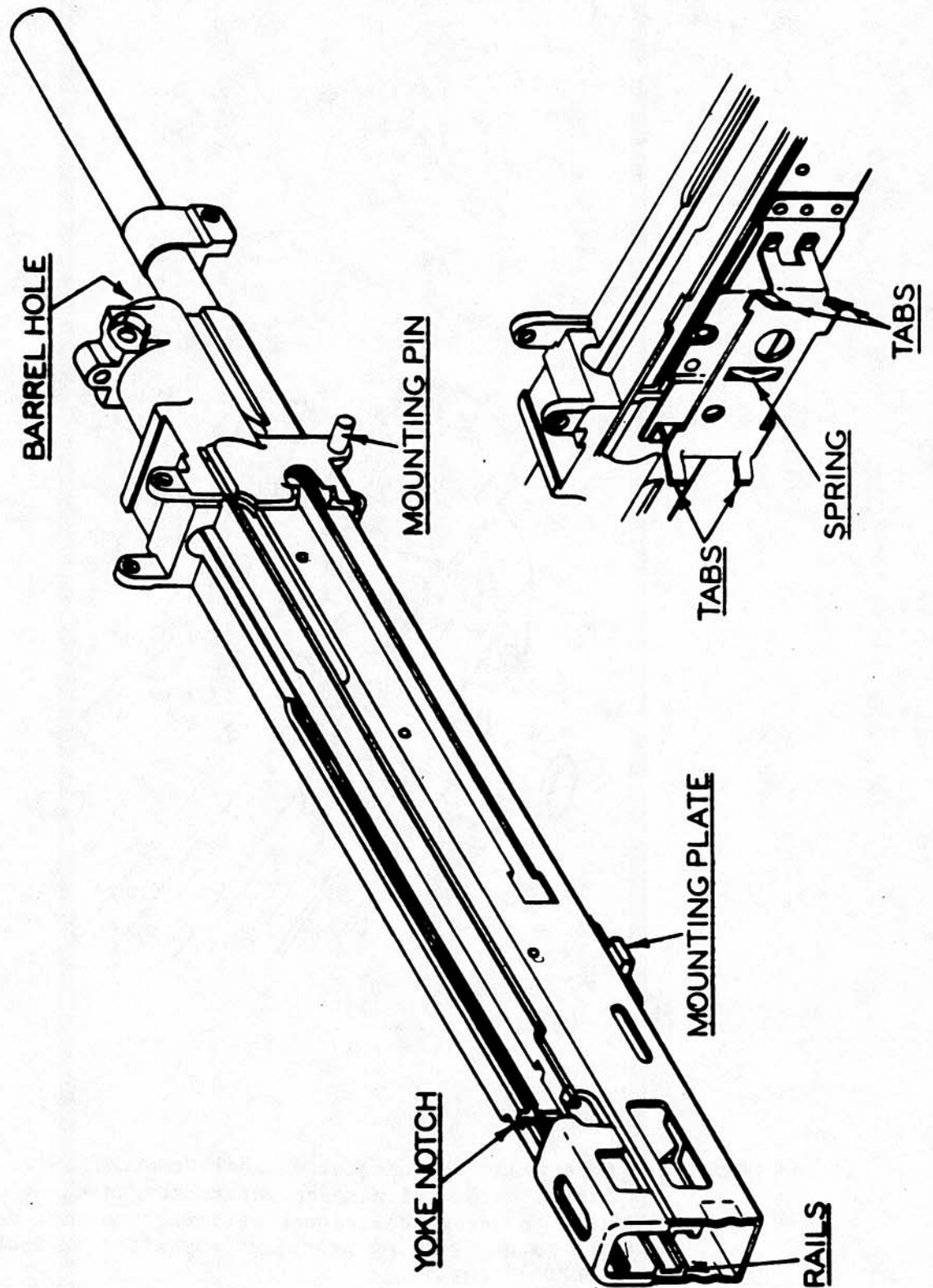
APPLICABLE SPECIFICALLY
TO WEAPONS IN SERIAL # 35550-3750

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
5. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

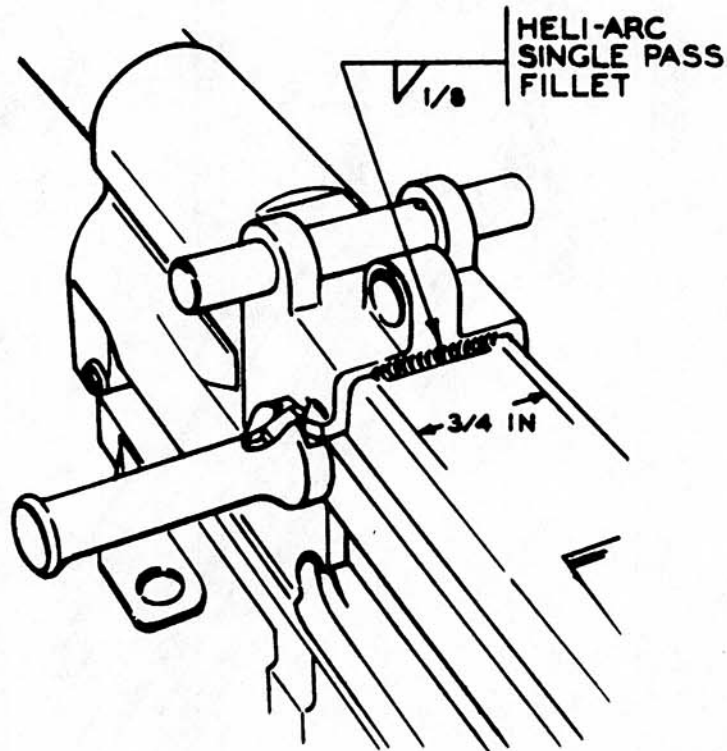
NOTE: All types shown in figure on page 6 are acceptable for applications indicated.

PROCESS INSPECTION. See pages 4 and 5 for required modification.

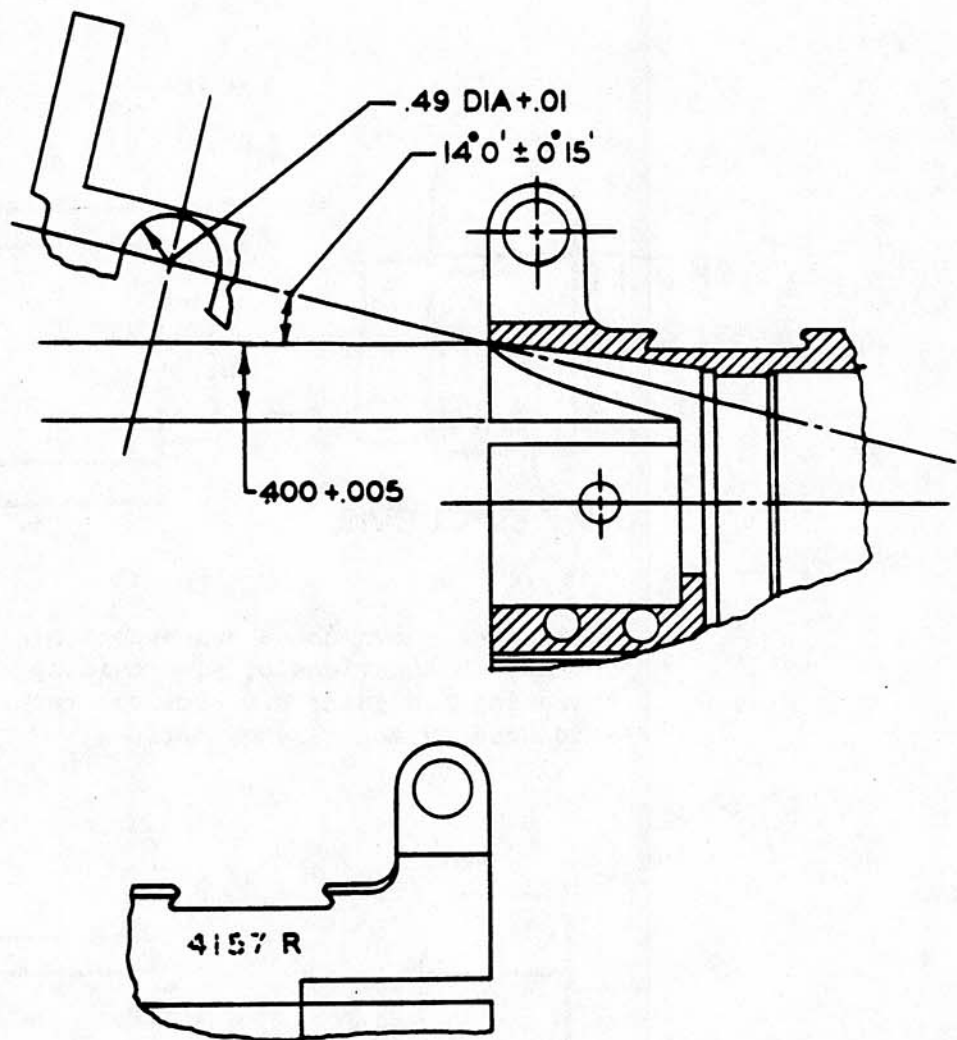
*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



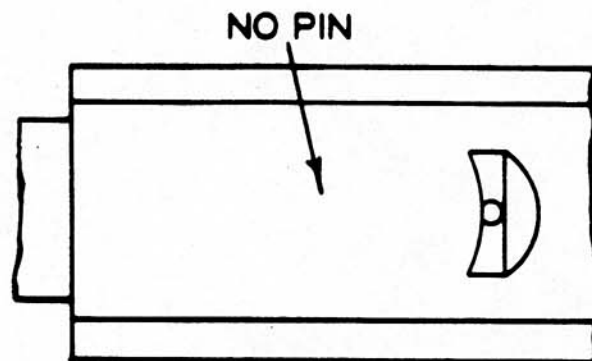
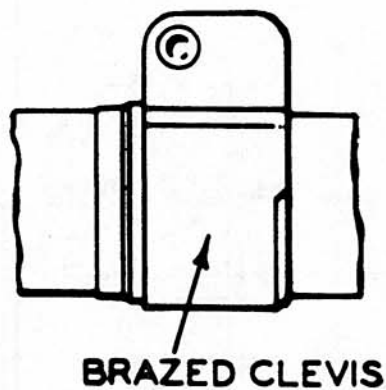
Note
Illustrated below is modification
required on weapons with serial numbers
35500 thru 37500 incl
ZFWO 9-1005-224-34/1 August 1963
see change #9 18 Nov 68



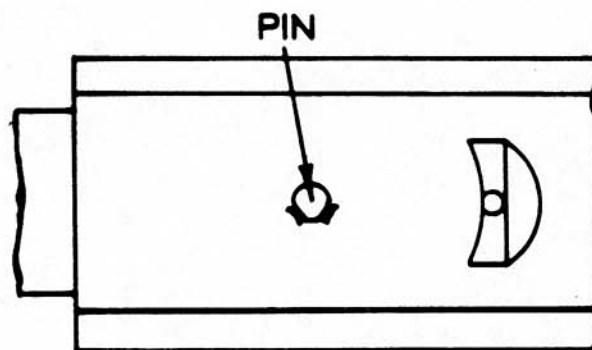
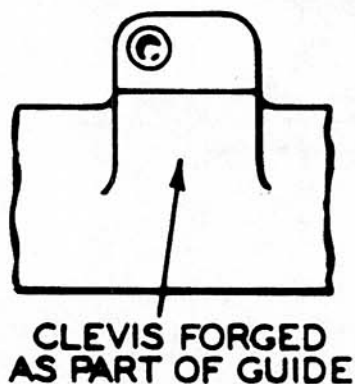
NOTE: The Government representative shall conduct surveillance of the supplier's reconditioning operation for rejected components on Defect 3 to assure compliance with requirements depicted above and the reconditioning procedure specified in Section 6 of USAWECOMDMI 1005-224.



NOTE: The Government representative shall conduct surveillance of the supplier's reconditioning process and stamping procedure to assure compliance with the requirements depicted above. See Section 6 of USAWECOMDMWI 1005-224 for reconditioning and gaging procedure.



Both types shown above are acceptable for M60 applications only, providing clevis and operating rod guide are securely retained as evidenced by manual examination.



Both types shown above are acceptable for both M60 and M60C applications.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

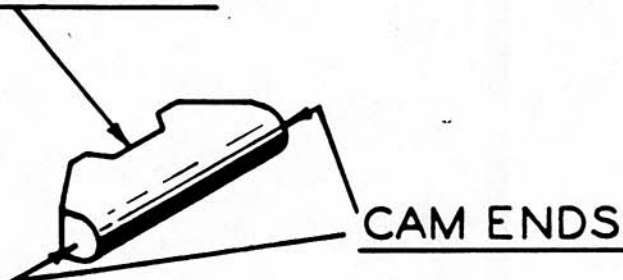
OIP - 7269237
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Retainer, Cocking Handle
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to plunger opening, and cam ends, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or-Defective Protective Coating	1.5	Visual	Phosphate Coating

PLUNGER OPENING



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

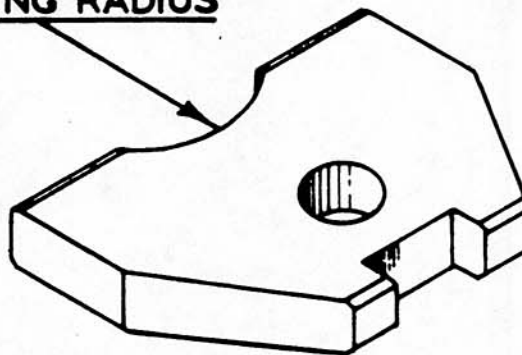
OIP-7269124
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Retainer, Feed Cam
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the retaining radius, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

RETAINING RADIUS



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269266
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Retainer, Spring
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pin hole, as indicated in the figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

PIN HOLE



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7791597
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Rod Assembly, Operating
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

Important: Further Disassembly is not required

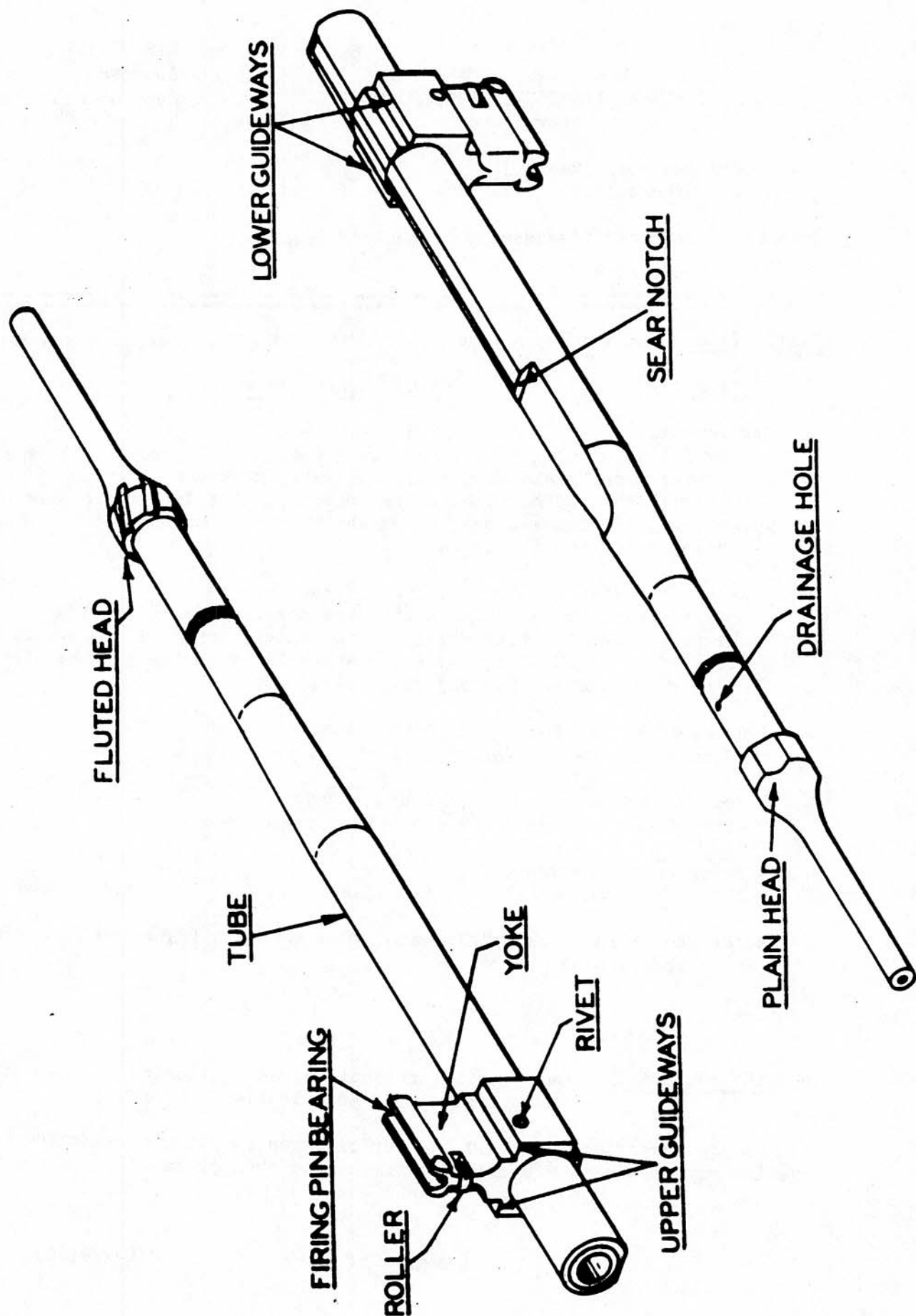
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

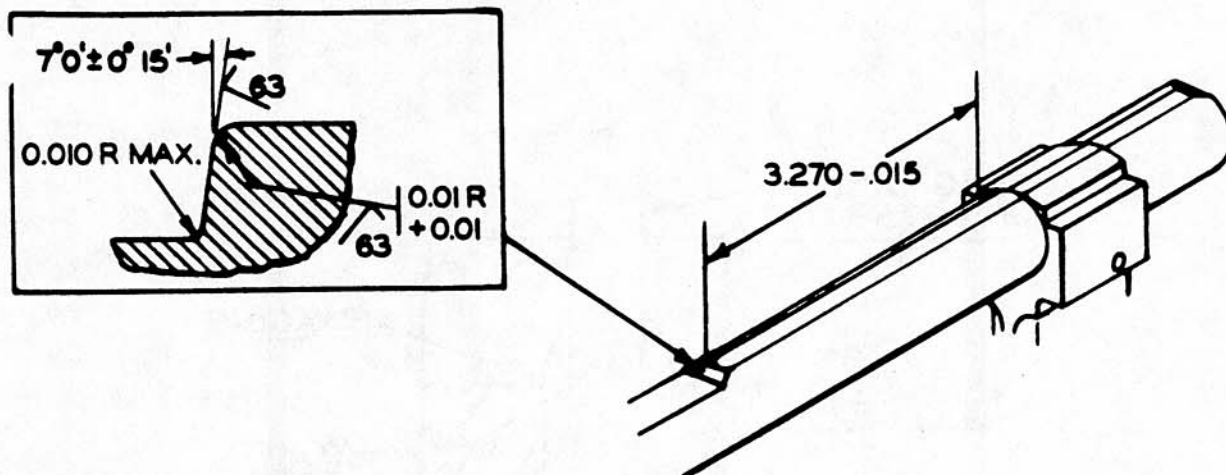
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the rear of yoke in roller area for cracks or breaks. Upsetting of metal at front and rear of yoke is permissible if burrs have been removed. The firing pin bearing groove, guideways and sear notch shall be free of burrs or mutilations. See figure on page 2.)	0.65	Visual	
2. Improper Assembly (Roller shall be assembled with large chamfer toward the tube and the roller shall rotate freely. The roller pin shall be securely retained in yoke. The head and yoke shall be secure to tube with no relative movement. See figure on page 2.)	0.65	Visual-Manual	
3. Improper Modification (Missing drainage hole. See figure on page 2.)	0.65	Visual	
4. Improper Parts (See figure on page 4 for inspection procedure.)	0.65	7799756	
5. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

NOTE: Both fluted and plain head types shown in figure on page 2 are acceptable.

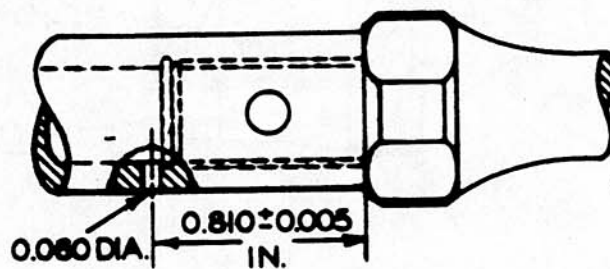
PROCESS INSPECTION. See page 3 for required reconditioning of sear notch and drainage hole modification.

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



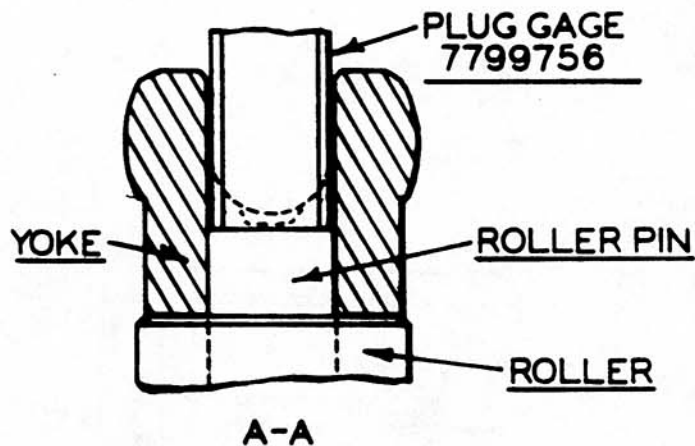
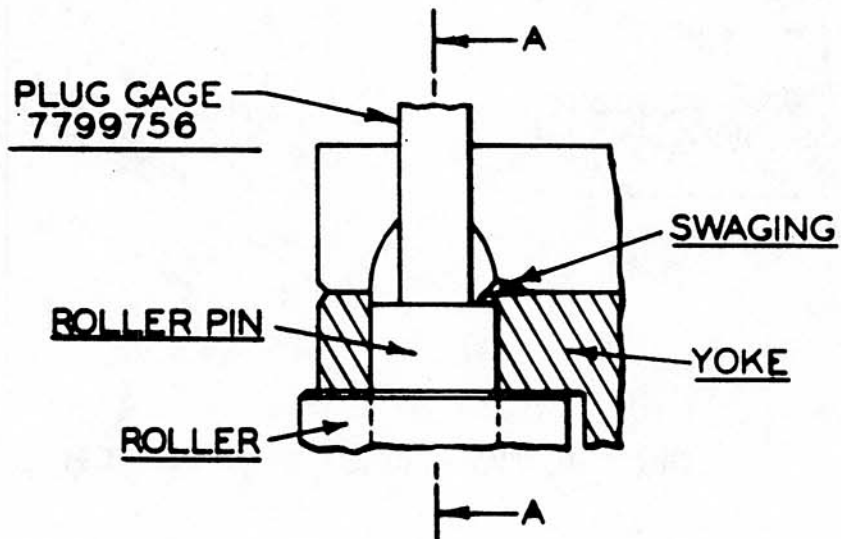


RECONDITIONING OF SEAR NOTCH



MODIFICATION OF DRAIN HOLE

NOTE: The Government representative shall conduct surveillance of the supplier's reconditioning of the sear notch and modification of the drain hole, to assure compliance with requirements depicted above.



Operating rod assemblies shall be inspected for presence of proper roller and pin by the method depicted above. Plug gage shall be positioned with flat clearing swaging as indicated in top figure and shall enter pin hole and seat on top of pin as indicated in bottom figure. Failure of plug to enter pin hole and seat on pin shall be cause for rejection, disassembly of pin and roller, rework of yoke, and reassembly of new pin and roller as specified in Section 6 of USAWECOMDMWI 1005-224.

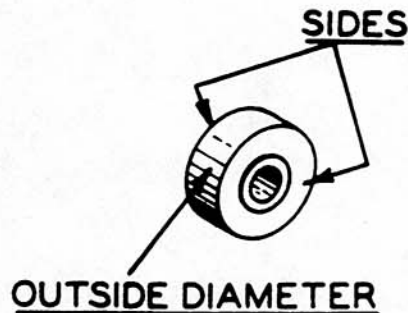
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269333
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Roller, Cartridge Feed
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the outside diameter and sides, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

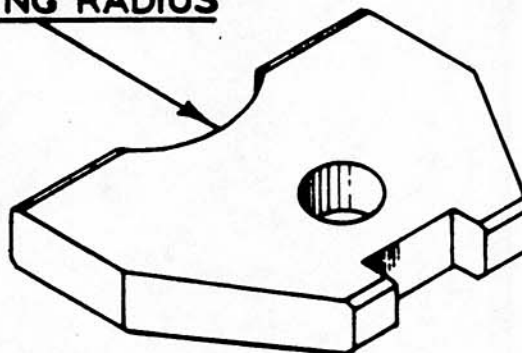
OIP-7269124
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Retainer, Feed Cam
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the retaining radius, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

RETAINING RADIUS



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269266
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Retainer, Spring
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pin hole, as indicated in the figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

PIN HOLE



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7791597
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Rod Assembly, Operating
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

Important: Further Disassembly is not required

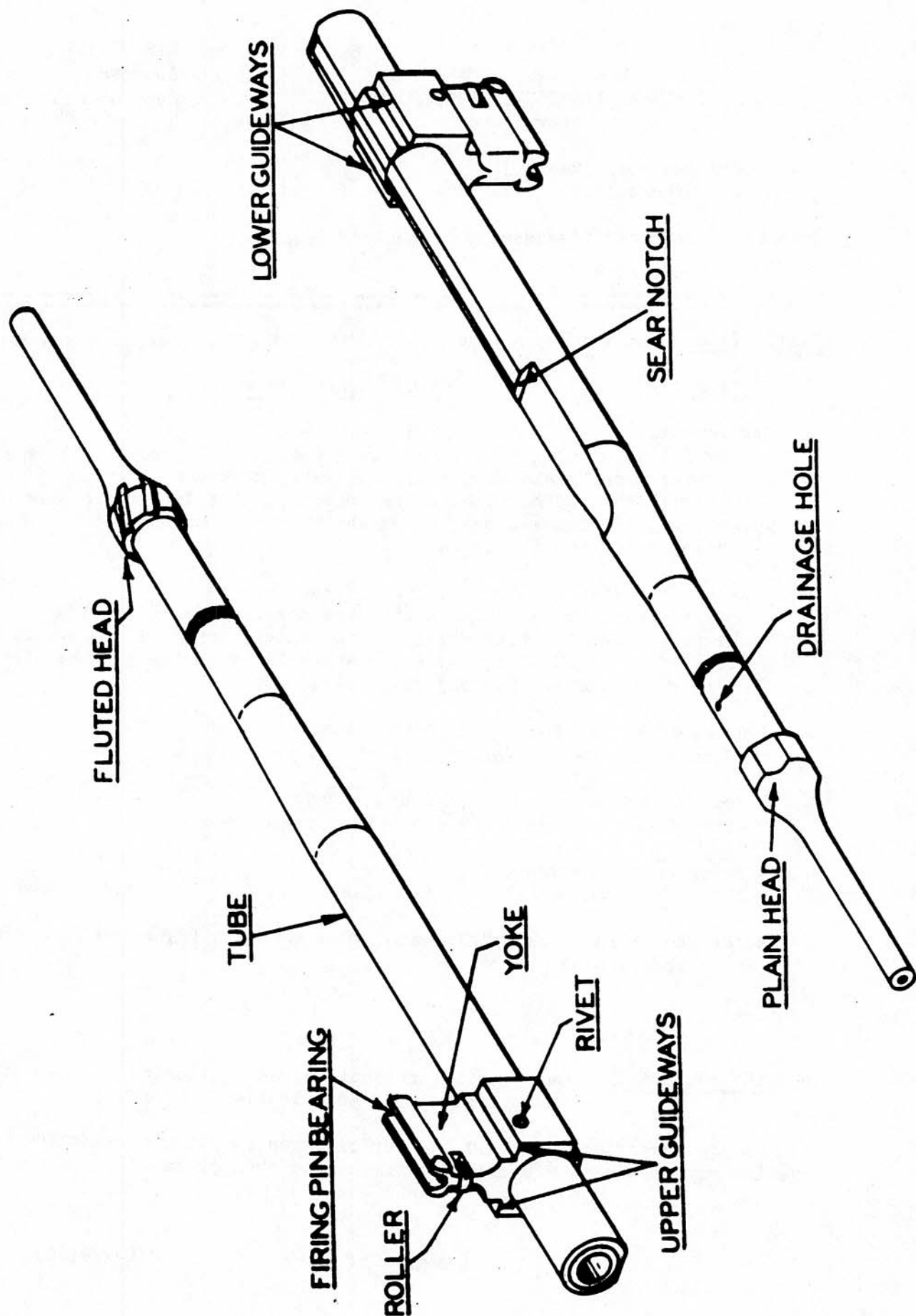
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

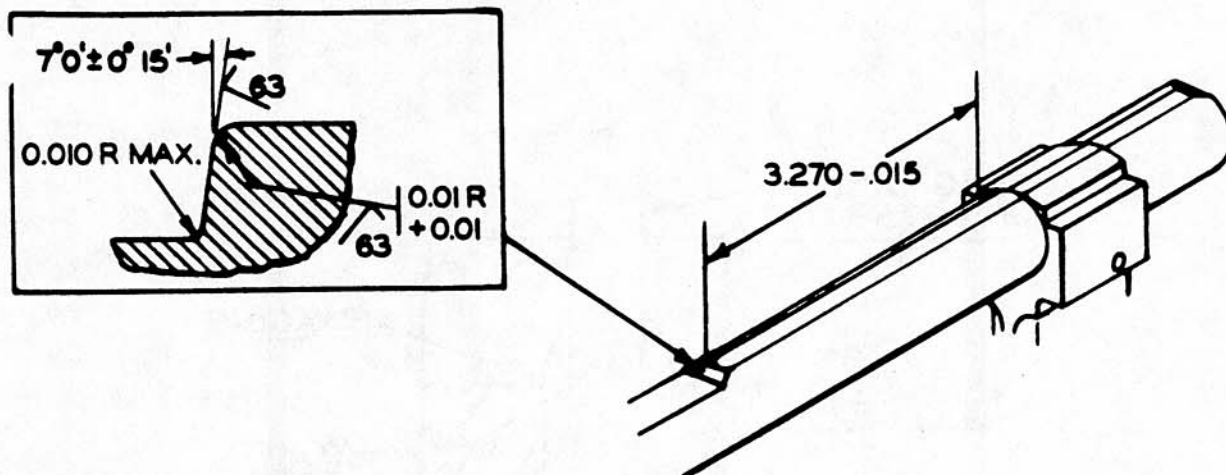
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the rear of yoke in roller area for cracks or breaks. Upsetting of metal at front and rear of yoke is permissible if burrs have been removed. The firing pin bearing groove, guideways and sear notch shall be free of burrs or mutilations. See figure on page 2.)	0.65	Visual	
2. Improper Assembly (Roller shall be assembled with large chamfer toward the tube and the roller shall rotate freely. The roller pin shall be securely retained in yoke. The head and yoke shall be secure to tube with no relative movement. See figure on page 2.)	0.65	Visual-Manual	
3. Improper Modification (Missing drainage hole. See figure on page 2.)	0.65	Visual	
4. Improper Parts (See figure on page 4 for inspection procedure.)	0.65	7799756	
5. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

NOTE: Both fluted and plain head types shown in figure on page 2 are acceptable.

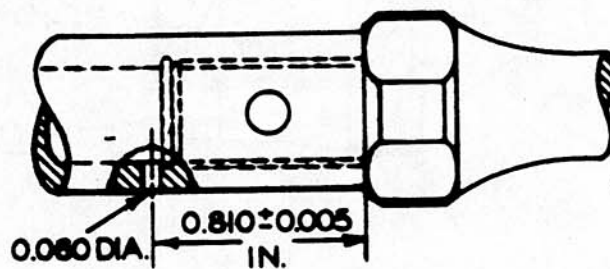
PROCESS INSPECTION. See page 3 for required reconditioning of sear notch and drainage hole modification.

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



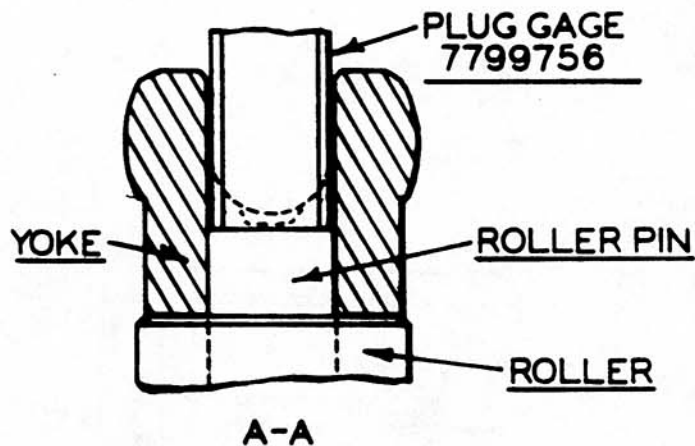
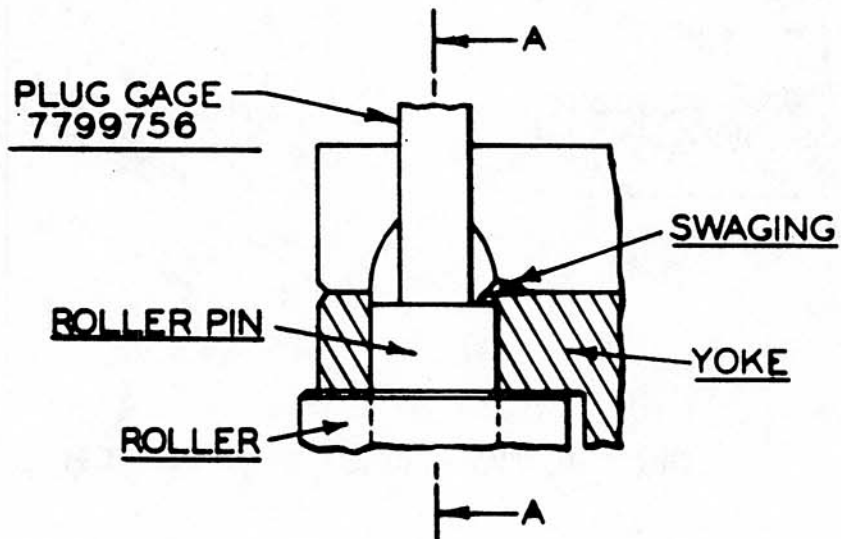


RECONDITIONING OF SEAR NOTCH



MODIFICATION OF DRAIN HOLE

NOTE: The Government representative shall conduct surveillance of the supplier's reconditioning of the sear notch and modification of the drain hole, to assure compliance with requirements depicted above.



Operating rod assemblies shall be inspected for presence of proper roller and pin by the method depicted above. Plug gage shall be positioned with flat clearing swaging as indicated in top figure and shall enter pin hole and seat on top of pin as indicated in bottom figure. Failure of plug to enter pin hole and seat on pin shall be cause for rejection, disassembly of pin and roller, rework of yoke, and reassembly of new pin and roller as specified in Section 6 of USAWECOMDMWI 1005-224.

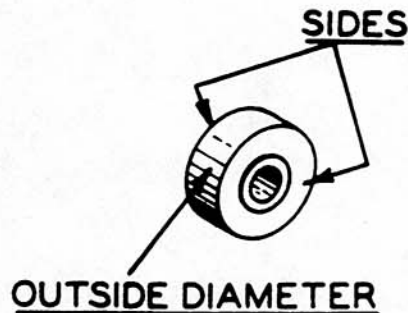
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269333
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Roller, Cartridge Feed
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the outside diameter and sides, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP - 7790559
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Screw, Machine, w/Lock Washer
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the threads, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

THREADS



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

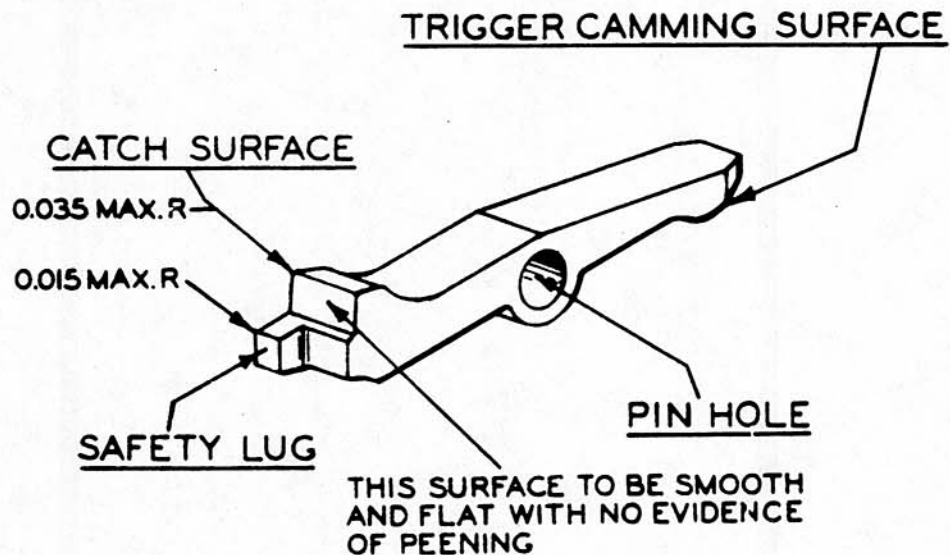
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269209
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Sear
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the trigger camming surface, catch surface, safety lug and pin hole, as indicated in the figure below, for burrs, chipping, or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

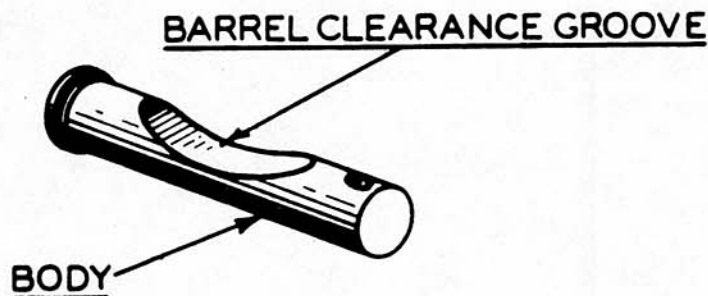
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269276
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Shaft, Barrel Locking
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the barrel clearance groove and body, as indicated in the figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

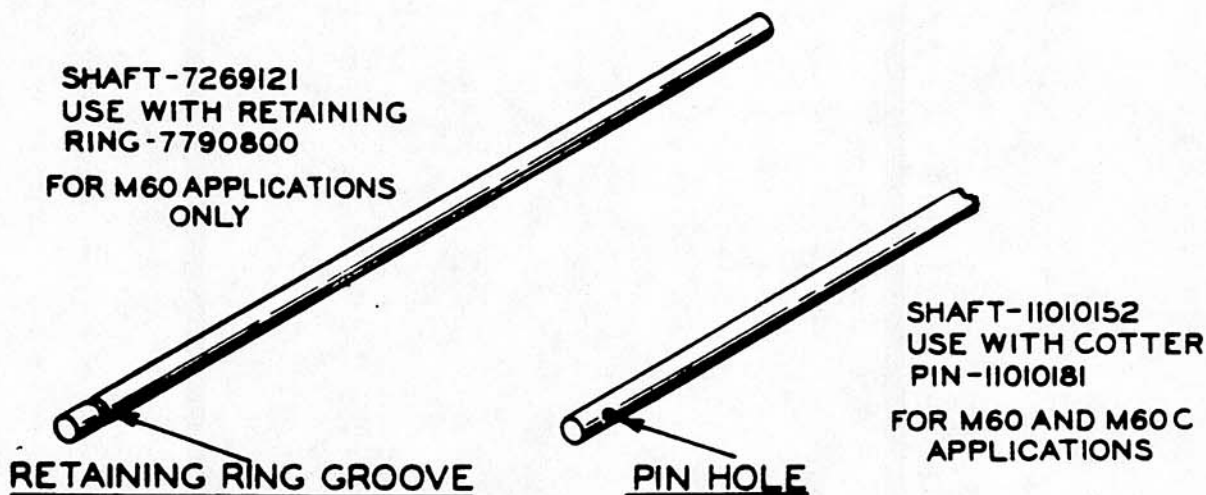
OIP-11010152
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Shaft, Cartridge Guide
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the retaining ring groove, or pin hole as indicated in the figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

NOTE: Both designs shown in figure below are acceptable for applications indicated.



*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

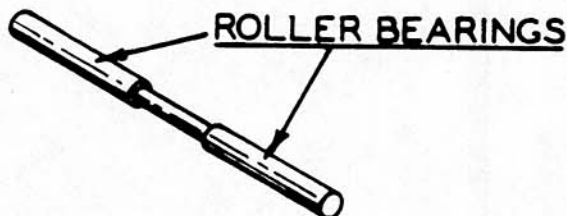
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP - 7790724
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Shaft, Cartridge Pawl
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the roller bearings, as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269239

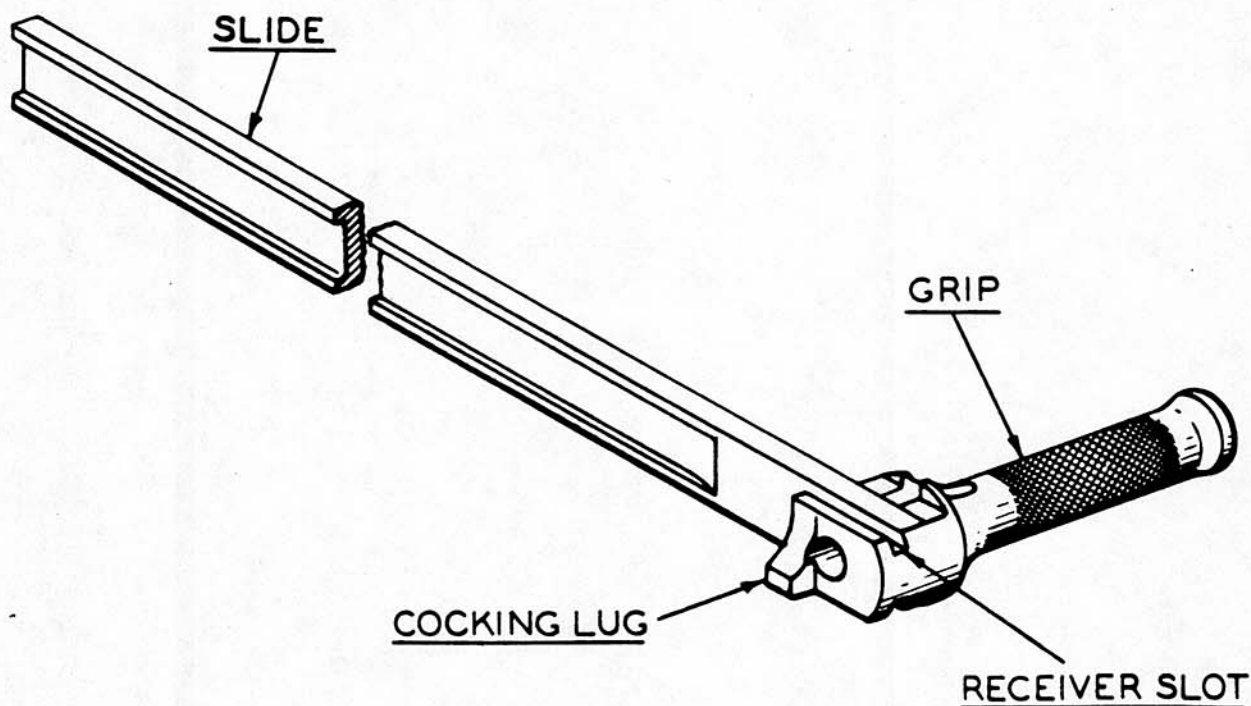
Approved: 28 May 65

Supplementary to:
USAWECOMDMWI 1005-224

Item: Slide Assembly, Cocking Handle
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the cocking lug and receiver slot for burrs or mutilations and to the grip to assure that it is securely brazed to slide. See figure below.)	0.65	Visual-Manual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U.S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269303
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

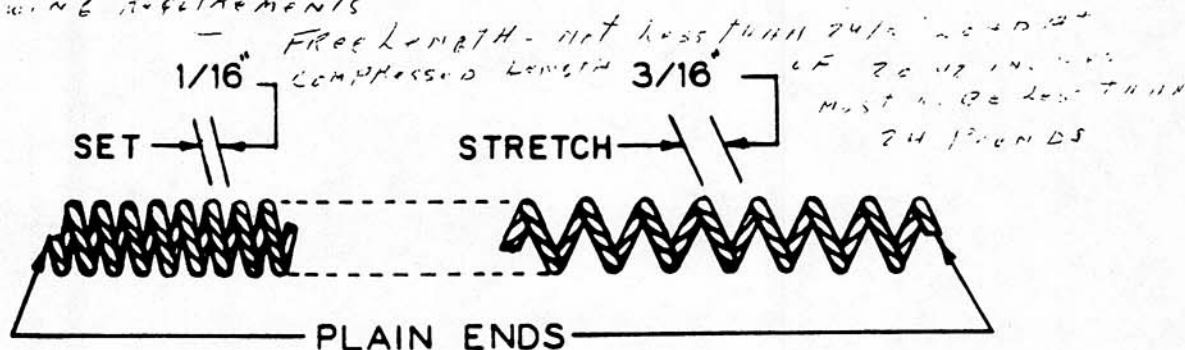
Item: Spring, Driving
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Overall Length, Under ^{CHANGE #10} <i>See Note Below - CHANGE #10</i>	0.65	Measure	24 5/8 Min.
2. Distortion (Spring shall fall within 2 parallel lines 1 inch apart.)	0.65	Visual-Measure	
3. Serviceability (Particular attention shall be given to spring for broken coils, proper ends and to stretch or set, as indicated in figure below. Questionable springs showing evidence of extensive wear maybe checked for broken strands by twisting questionable areas. Broken strands are evidenced by an audible click	0.65	Visual-Manual	

NOTE: Springs shall be considered acceptable with or without black Oxide coating and shall be clean and free of foreign matter.

Note #2. SPRINGS WHICH ARE BELOW ACCEPTED 24 5/8 MINIMUM FREE LENGTH MAY BE QUALIFIED FOR OVERHAUL IF THEY MEET THE FOLLOWING REQUIREMENTS



*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

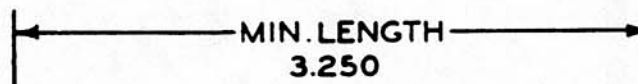
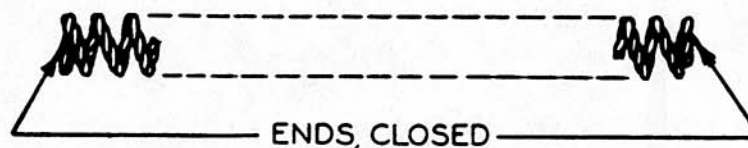
OIP-7269087
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Firing Pin
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given springs for length and proper ends, as indicated in figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be clean and free of foreign matter.



COMPARISON GAGE

Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

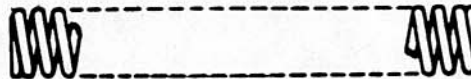
*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269085
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Ejector Plunger)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.



(ENLARGED VIEW)

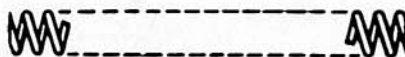
Helical compression springs (7269085) used with ejector shall be replaced in all overhauled weapons. No ejector springs will be reused.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP - 7269086
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Extractor Plunger)
for Overhaul of the Machine Guns, 7.52MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.



(ENLARGED VIEW)

Helical compression springs (7269086) used with extractor plungers shall be replaced in all overhauled weapons. No extractor plunger springs will be reused.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

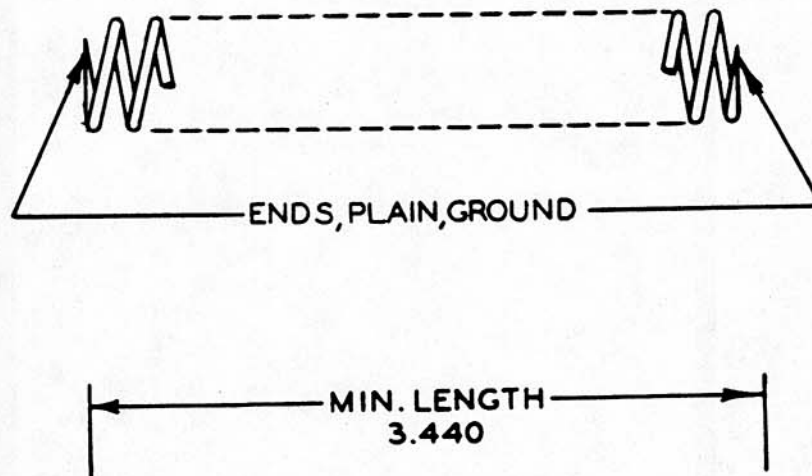
OIP - 7269105
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Buffer Assembly)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for length and proper ends as indicated in figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without Black Oxide coating and shall be clean and free of foreign matter.



COMPARISON GAGE
Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

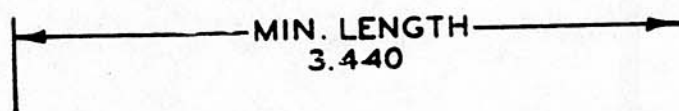
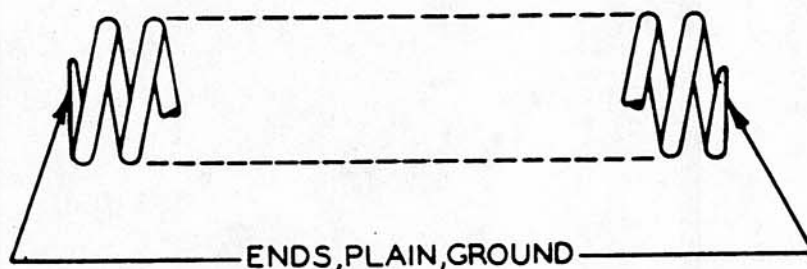
OIP-7269106
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Buffer Assembly)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for length and proper ends, as depicted in figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be clean and free of foreign matter.



COMPARISON GAGE
Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

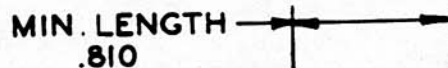
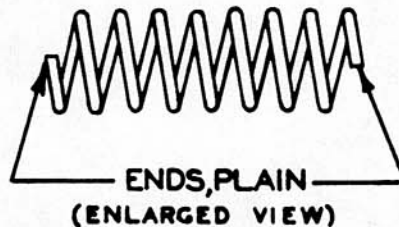
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP - 7269107
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Buffer Assembly)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for length and proper ends as indicated in figure below.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Black Oxide Coating



COMPARISON GAGE

Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQ:'s are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

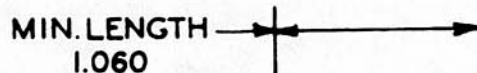
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269108
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Buffer Assembly)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to springs for length and proper ends, as indicated in figure below.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Black Oxide Coating



COMPARISON GAGE

Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

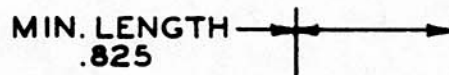
OIP-7269125
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Feed Cam Retainer)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability	0.65	Visual	
(Particular attention shall be given to spring for length and proper ends, as indicated in figure below.)			

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be clean and free of foreign matter.



COMPARISON GAGE

Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

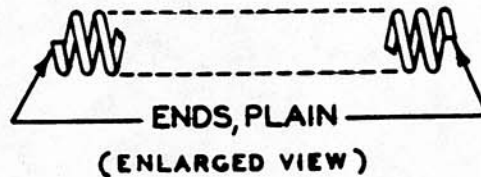
OIP-7269211
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Sear, Plunger)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability	0.65	Visual	
(Particular attention shall be given to spring for length and proper ends, as indicated in figure below.)			

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be clean and free of foreign matter.



COMPARISON GAGE

Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269300
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Barrel Lock Lever)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for length and proper ends, as indicated in figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be clean and free of foreign matter.



MIN. LENGTH 1.285

COMPARISON GAGE

Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

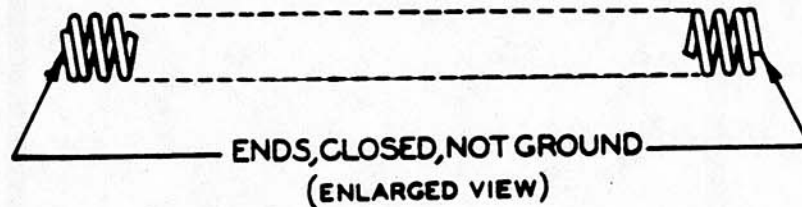
OIP-7791522
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Cocking Handle)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for length and proper ends as indicated in figure below.)	0.65	Visual	
2. Design Types (See Figure on Page 2 for acceptable design.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without Black Oxide coating and shall be clean and free of foreign matter.



COMPARISON GAGE
Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

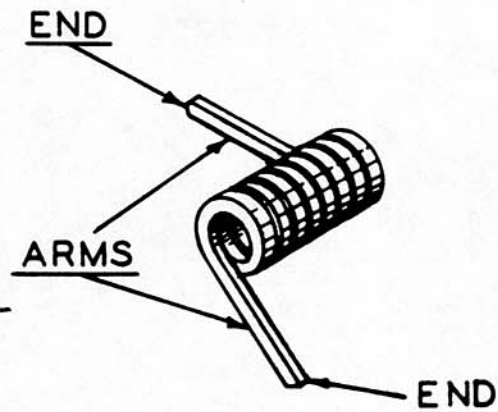
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269301
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Torsion (use with Cover Hinge)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for broken coils or ends and to distortion of arms. See figure below.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Black Oxide Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

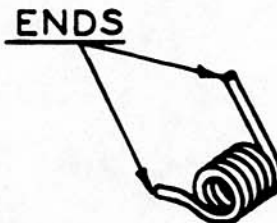
OIP - 7269335
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical, Torsion (use with Feed Tray)
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for broken coils or ends. See figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without Black Oxide coating and shall be clear and free of foreign matter.



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

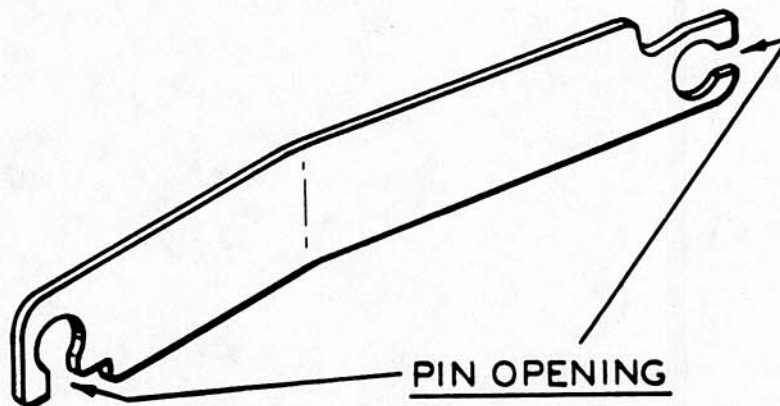
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP - 7792398
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Lock, Retainer Pin
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Design Type (See Figure on page 2 for acceptable design)	0.65	Visual	
2. Serviceability (Particular attention shall be given the pin openings, as indicated in the figure below, for burrs or mutilations.)	0.65	Visual	
3. Missing or Defective Protective Coating	1.5	Visual	Black Oxide



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

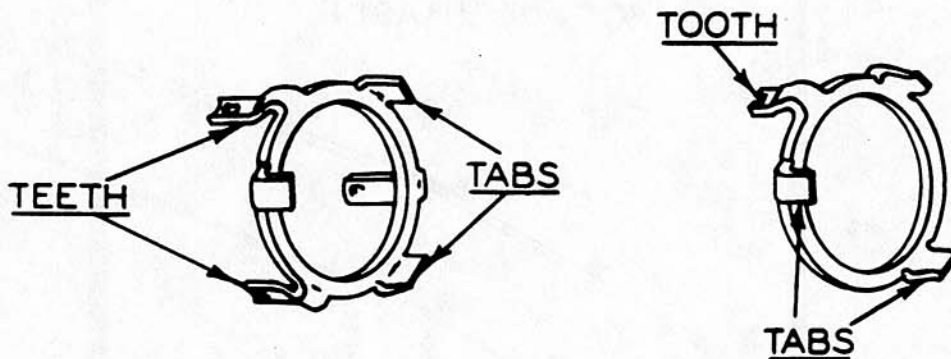
OIP-7269035
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Washer, Lock
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

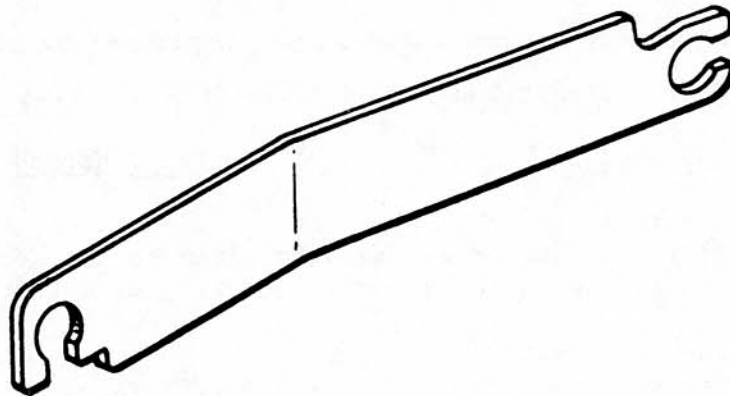
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the locking tabs and teeth, as indicated in the figure below, for cracks or burrs.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Black Oxide Coating

NOTE: Both designs shown in figure below are acceptable.

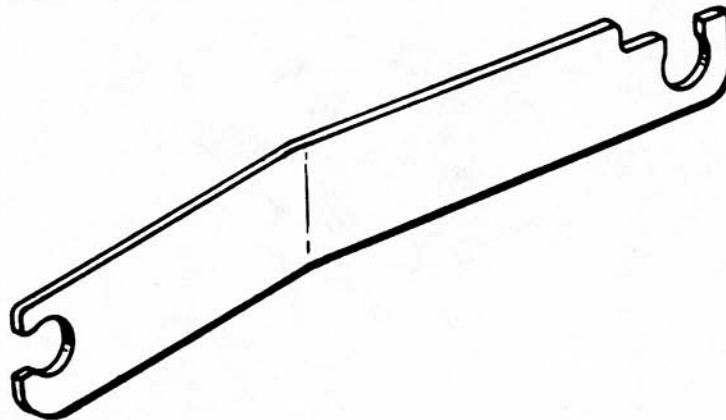


*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

ACCEPTABLE



NOT ACCEPTABLE



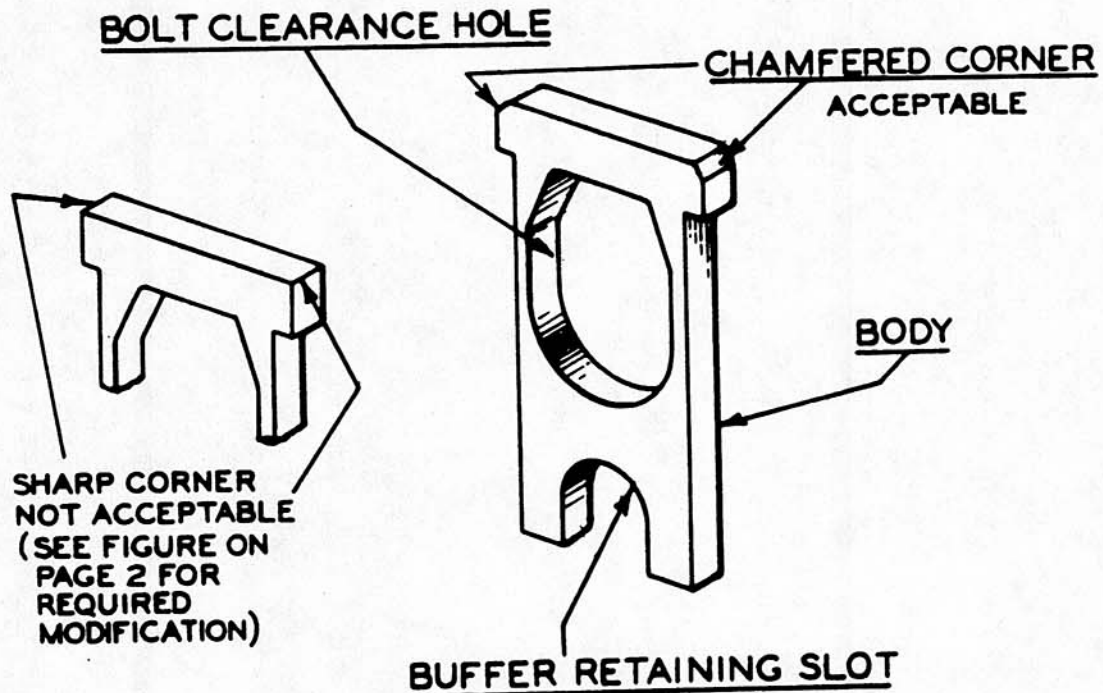
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269344
Approved: 28 May 65:
Supplementary to:
USAWECOMDMWI 1005-224

Item: Yoke, Buffer Retaining
for Overhaul of the Machine Guns, 7.62MM, M60 and M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

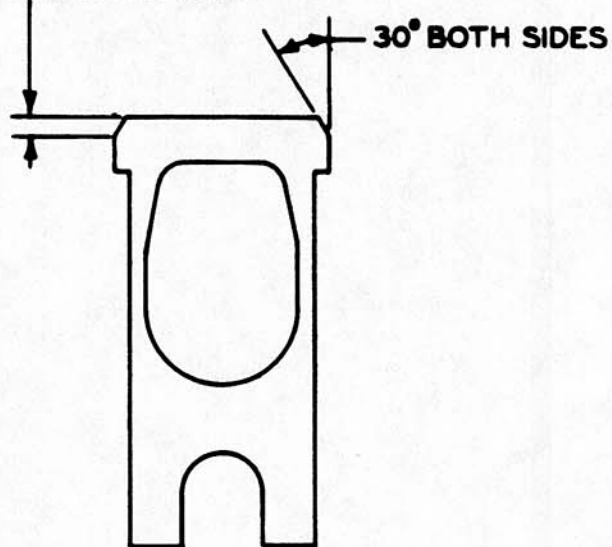
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the bolt clearance hole, chamfers, body, and buffer retaining slot, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Improper Modification (See figure below)	0.65	Visual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



PROCESS INSPECTION. See page 2 for required modification.

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

.055+.020 BOTH SIDES



30° BOTH SIDES

NOTE: The Government representative shall conduct surveillance of the suppliers reconditioning operation for rejected components on Defect 2, to assure compliance with requirements depicted above.

PART III

INDEX OF OVERHAUL INSPECTION PROCEDURES
 APPLICABLE ONLY TO
 Machine Gun 7.62MM, M60
 (To be used in addition to OIP's in Part II)

<u>OIP NUMBERS</u>	<u>NOMENCLATURE DESCRIPTION</u>
MS19061-5	Ball, Bearing
7269028	Barrel Assembly, w/Pivot
7269278	Base Assembly, Rear Sight
7269180	Catch, Forearm
7269055	Foot Assembly, L.H.
7269061	Foot Assembly, R.H.
7269168	Forearm Assembly (w/o Spring, Pin and Catch)
7269231	Handle Assembly, Carrying
7269056	Housing Assembly, Foot, L.H. w/Button and Spring
7269062	Housing Assembly, Foot, R.H. w/Button and Spring
7269203	Housing Assembly, Trigger
7269057	Key, Guide, Foot
7269279	Leaf Assembly, Rear Sight
7269184	Pin, Catch, Forearm
7269246	Pin, Handle
7269048	Pin, Retainer, Spring
7269204	Pin, Trigger
7269250	Plunger, Carrying Handle
7269206	Plunger, Safety
7269050	Plunger, Spring, Leg
7269053	Retainer, Spring Leg
7269267	Ring, Handle Retaining
7790800	Ring, Snap
7269415	Safety
7269281	Screw, Windage
7269282	Slide, Screw
7269187	Spring, Catch Forearm
7269052	Spring, Helical Compression (use with Bipod Assembly)
7269210	Spring, Helical Compression (use with Safety Plunger)
7269283	Spring, Helical Compression (use with Base Rear Sight)
7269302	Spring, Helical Compression (use with Carrying Handle)
7269304	Stock Assembly, Butt
7269212	Trigger Assembly

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-MS19061-5
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Ball, Bearing
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Examine for mutilations or deformations.)	0.65	Visual	

BALL FOR
SIGHT ASSY. REAR
7209277



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269028
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Barrel Assembly, w/Pivot
for Overhaul of the Machine Gun, 7.62MM, M60

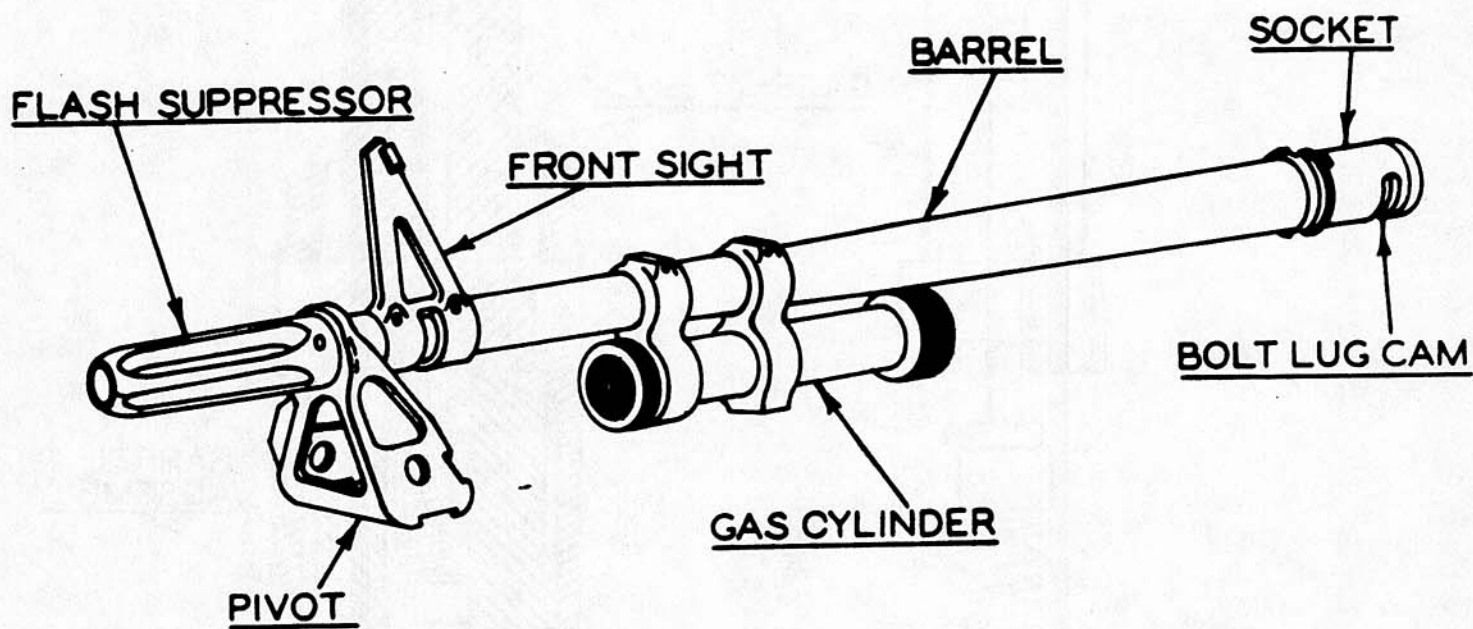
Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

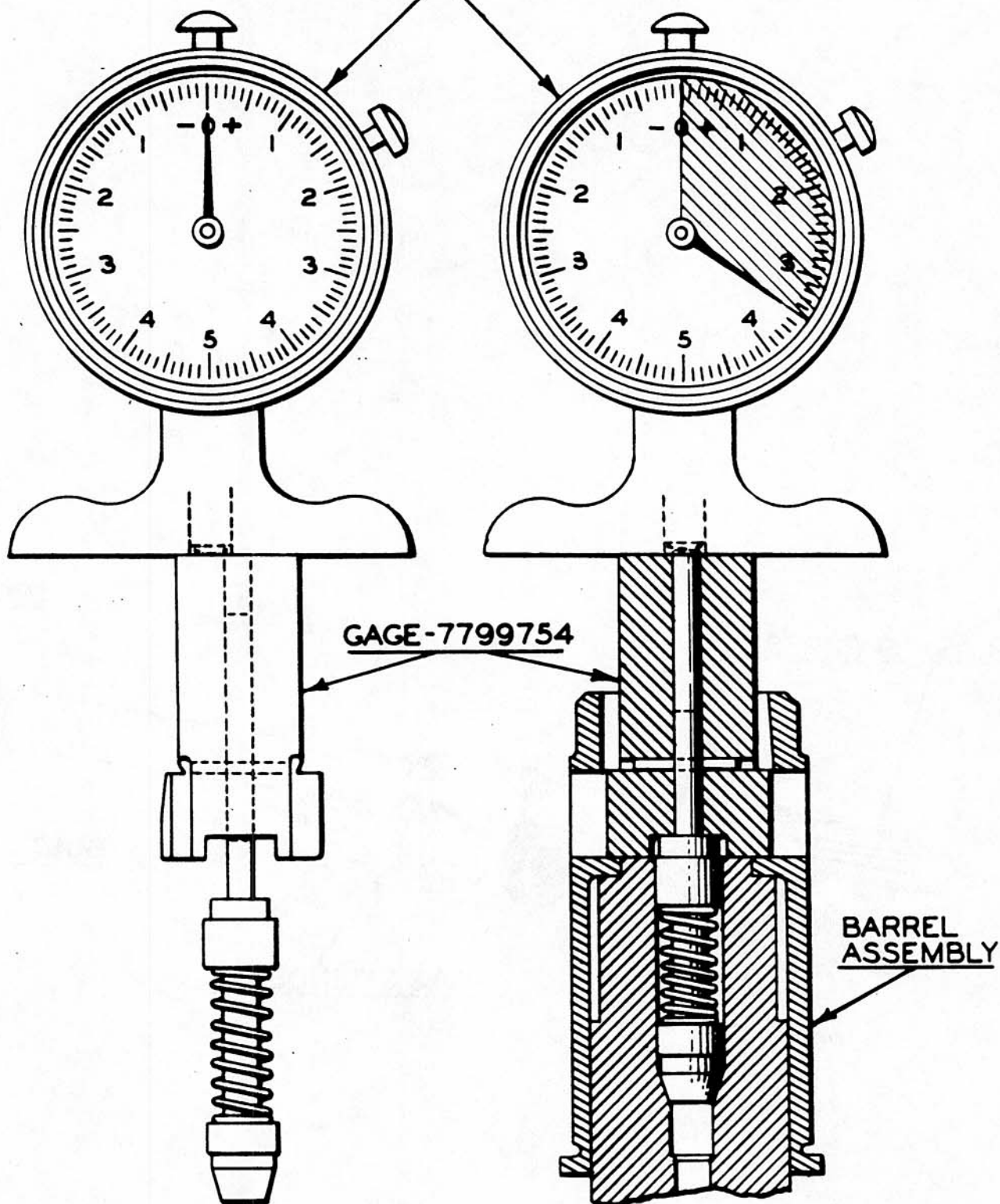
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the areas noted below and depicted in figure on page 3.)	0.65	Visual-Manual	
a. Flash Suppressor for cracks, burrs or mutilations.			
b. Front Sight for secureness to barrel and for chipping, cracks, burrs, mutilations or distortions.			
c. Gas Cylinder, (check serrations both ends for wear that would adversely affect retention of nut and extension, secureness of cylinder to barrel as determined by hand test, and diameter of piston hole for visible dents.)			
d. Socket, for chipping of bolt lug cams, burrs and secureness of socket to barrel.			
e. Socket, for cracks in bolt locking area.			
f. Pivot, for visible damage to threads and for detectable cracks.			
2. Headspace, Over	0.65	7799754 And Standard Dial Depth Gage (See figure on page 4)	1.638 Max.
3. Bore and Chamber	0.65	Visual	
a. Barrels will be straight as determined visually.			
b. Bore and chamber must be clean and free of corrosion.			
c. Pits as wide as a land or groove and three-eighths inch or less in length are allowable. Pits exceeding this acceptance criteria shall be cause for rejection.			
d. Scattered or uniformly fine pits or fine pits in a densely pitted area are allowable.			

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
<ul style="list-style-type: none"> e. Tool marks or scratches are acceptable regardless of length. Tool marks will appear as lines running laterally in the grooves or may run spirally across the top of the lands. f. Definitely ringed bores or bores ringed sufficiently to bulge the outside surface of the barrel are cause for rejection. Faint rings or shadowy depressions do not indicate an unserviceable barrel and should not be cause for rejection. g. Lands that appear dark due to coating of gilding metal from projectiles should not be cause for rejection. h. Stripped or flaked plating in the bore shall be cause for rejection. i. Particular attention shall be given area of liner just forward of bullet seat for chipping. 			
4. Diameter, Gas Port Hole, Under	0.65	A7799757	
5. Design Type (Pivot) (See figure on page 6 for acceptable type bipod pivot.)	0.65	Visual	
6. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating (Bore and chamber shall be free of protective coating.)

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



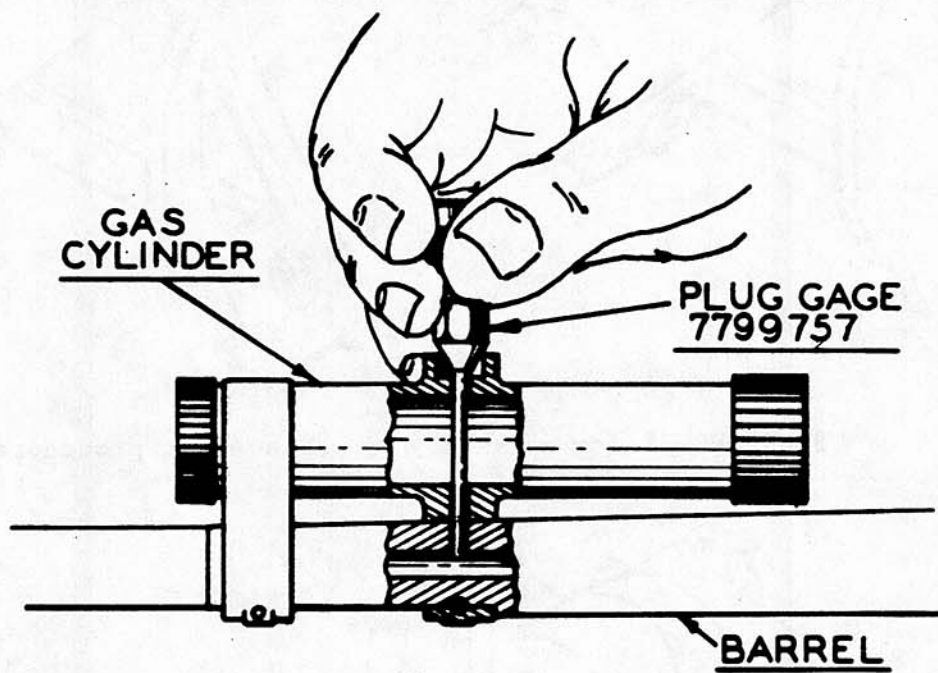
STANDARD DIAL DEPTH GAGE

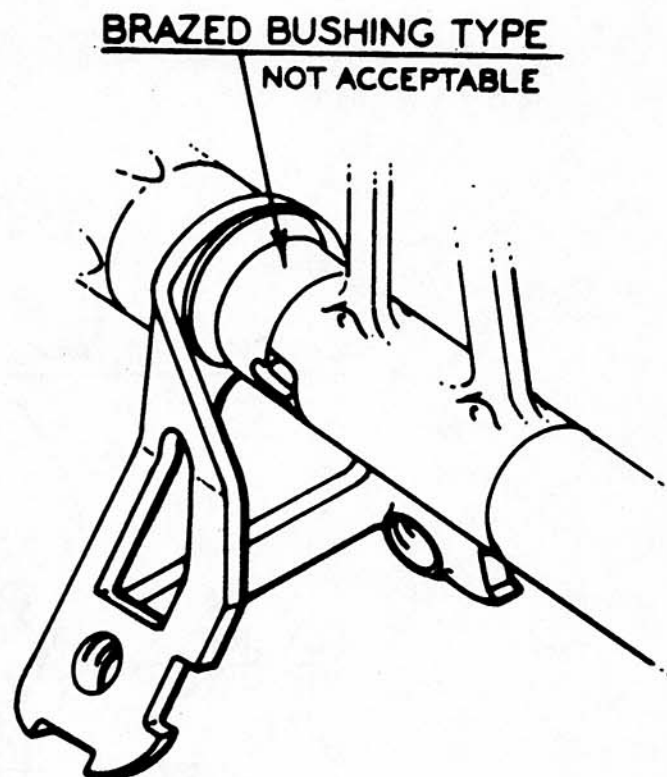
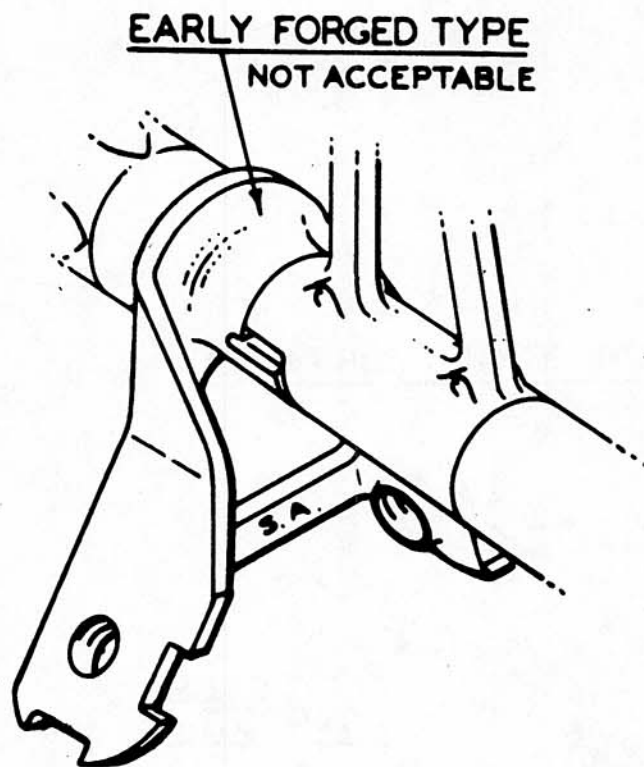


Headspace Gaging Procedure

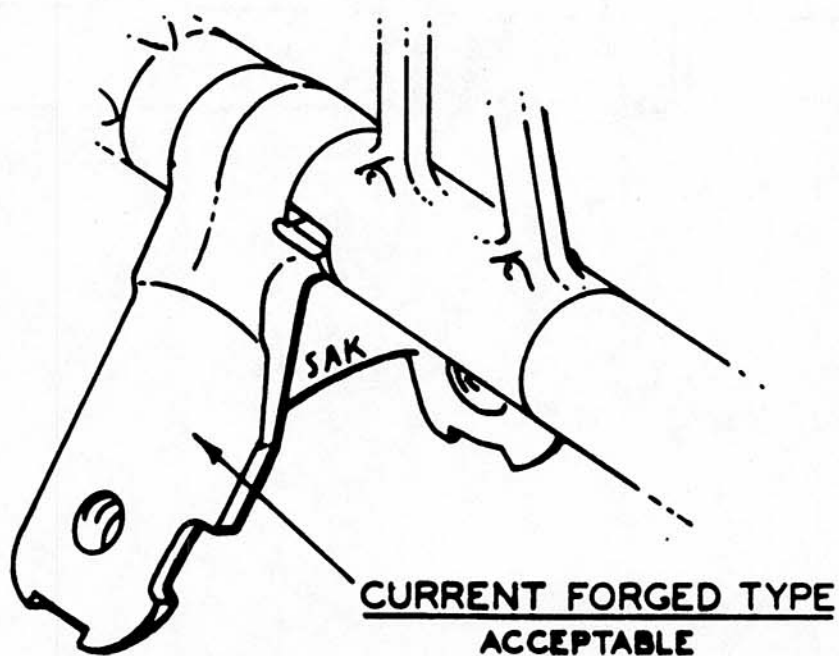
- Zero dial depth gage as shown in left view.
- Insert gage 7799754 into chamber, applying pressure to overcome spring load, and rotate to fully locked position.
- Flush pin of gage must be protruding from gage surface.
- Position dial depth gage as shown in right view.
- To be acceptable, flush pin of gage shall protrude a minimum of .0035 as indicated on dial depth gage.

CHECKING DIAMETER OF GAS PORT HOLE





See Section 6 of USAWECOMDMWI for removal and replacement procedure for above types.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

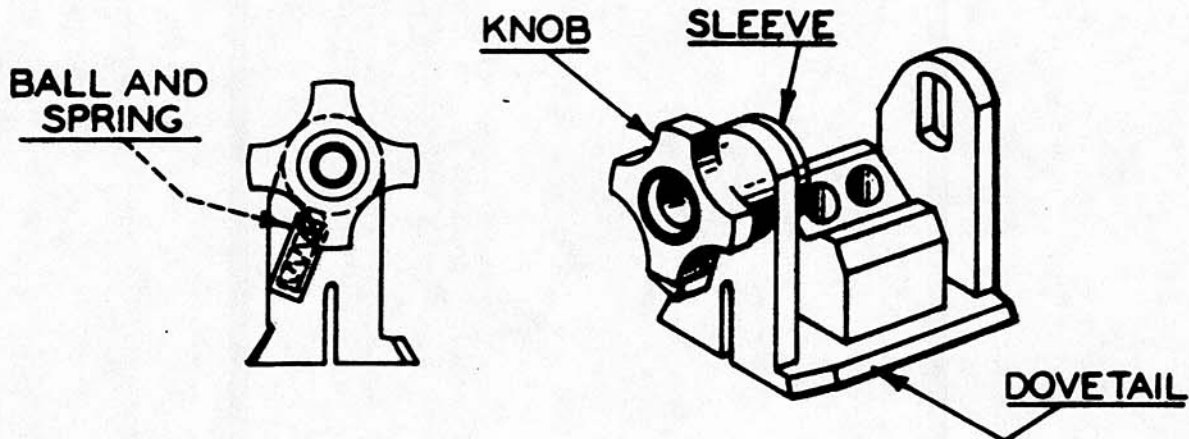
OIP-7269278
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Base Assembly, Rear Sight
for Overhaul of the Machine Gun, 7.62MM, M60

Important: Further disassembly is not required.

EXAMINATION. See Section 4. of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the dovetail for burrs and mutilations. The knob shall be retained securely by the staked sleeve and shall rotate freely under ball-spring load when manually operated. See figure below.)	0.65	Visual-Manual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

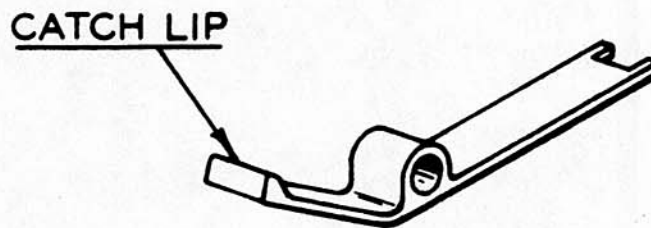
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269180
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Catch, Forearm
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the catch lip as indicated in the figure below for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

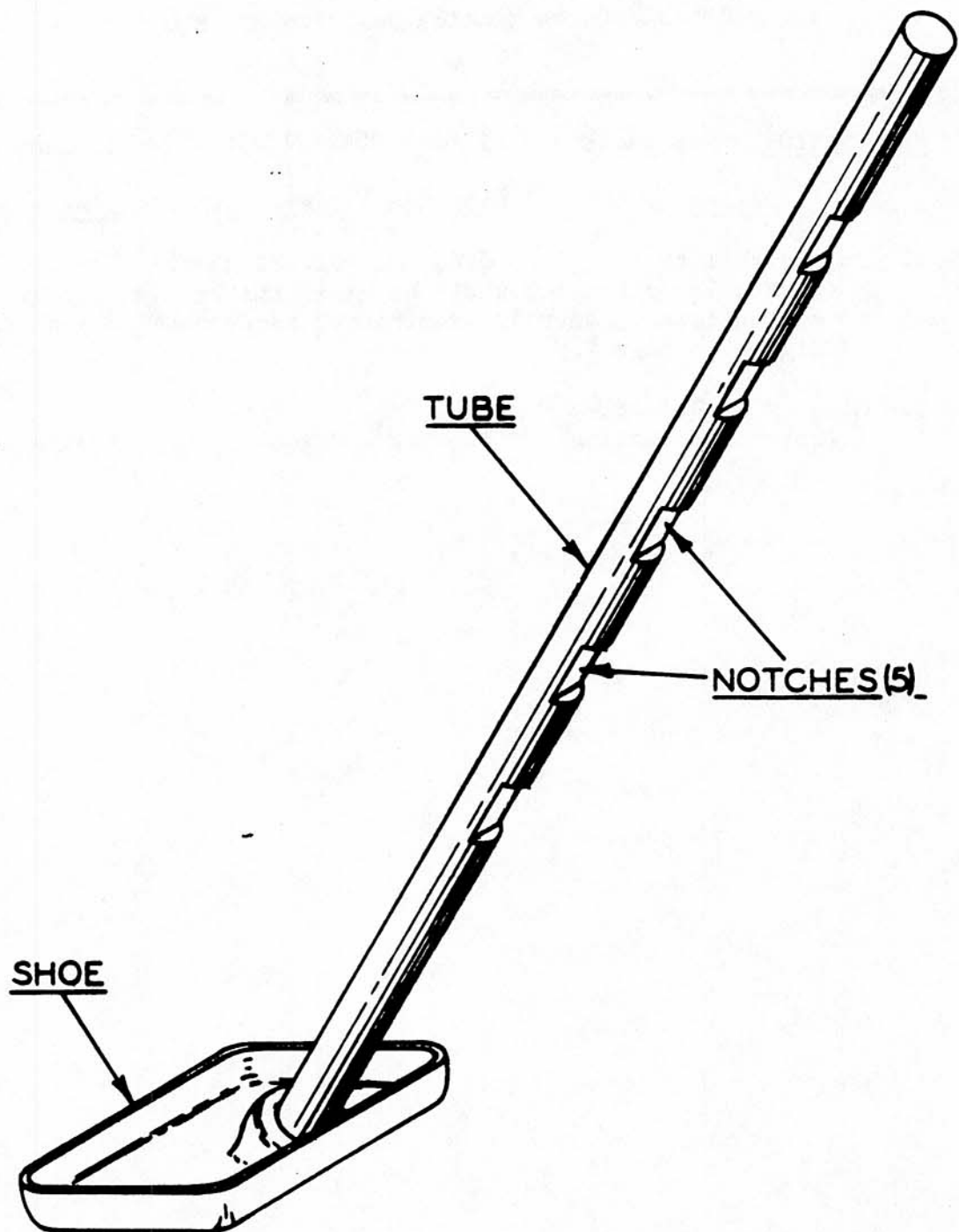
OIP-7269055
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Foot Assembly, L.H.
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the locking notches for burrs or mutilations. Manually examine for secureness of shoe to tube. See figure on page 2.)	0.65	Visual-Manual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

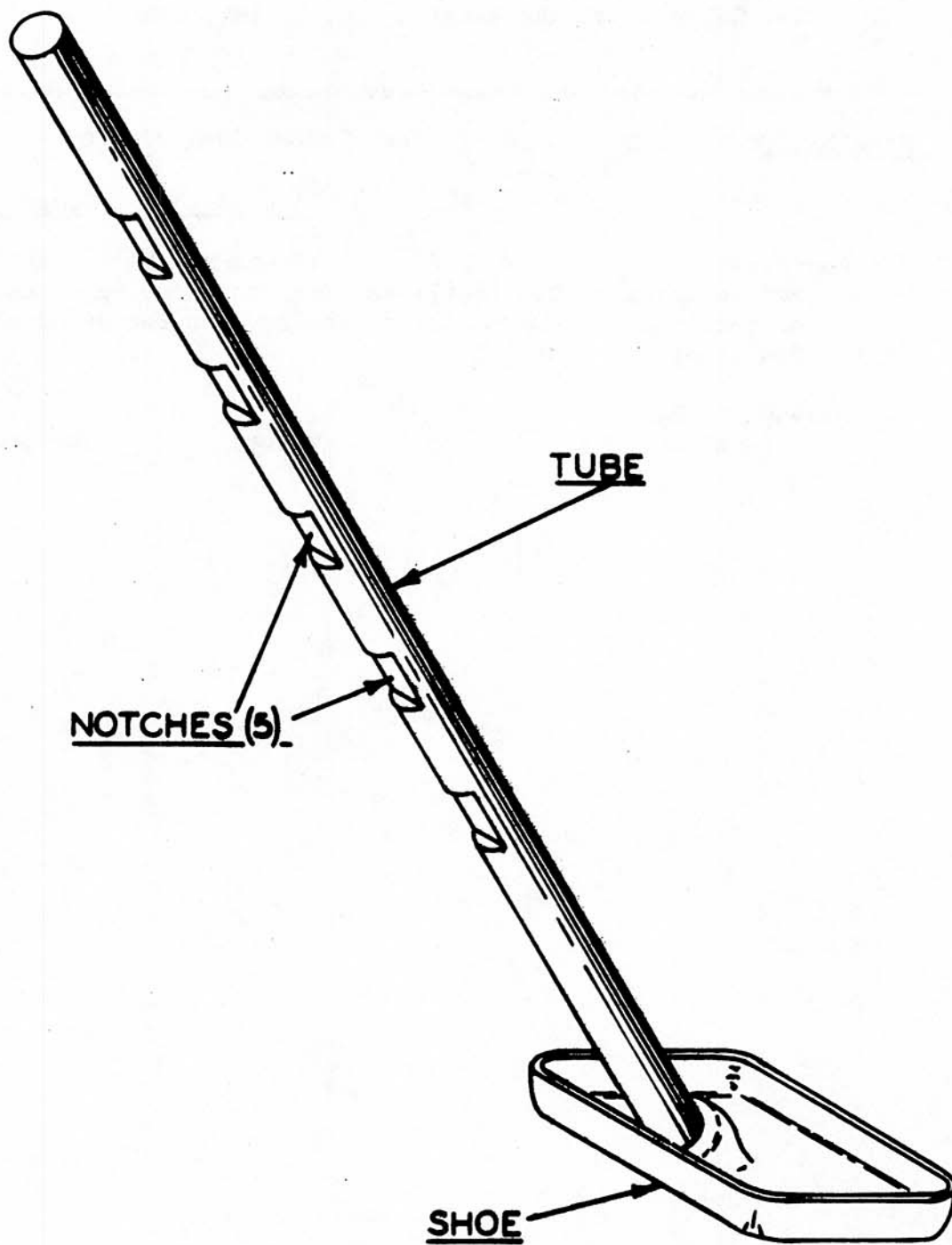
OIP-7269061
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Foot Assembly, R.H.
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the locking notches for burrs or mutilations. Manually examine for secureness of shoe to tube. See figure on page 2.)	0.65	Visual-Manual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

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Preliminary examination shall be performed on each piece.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
FOR

OIP-7269168
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Forearm Assembly (w/o Spring, Pin and Catch)
for Overhaul of the Machine Gun, 7.62MM, M60

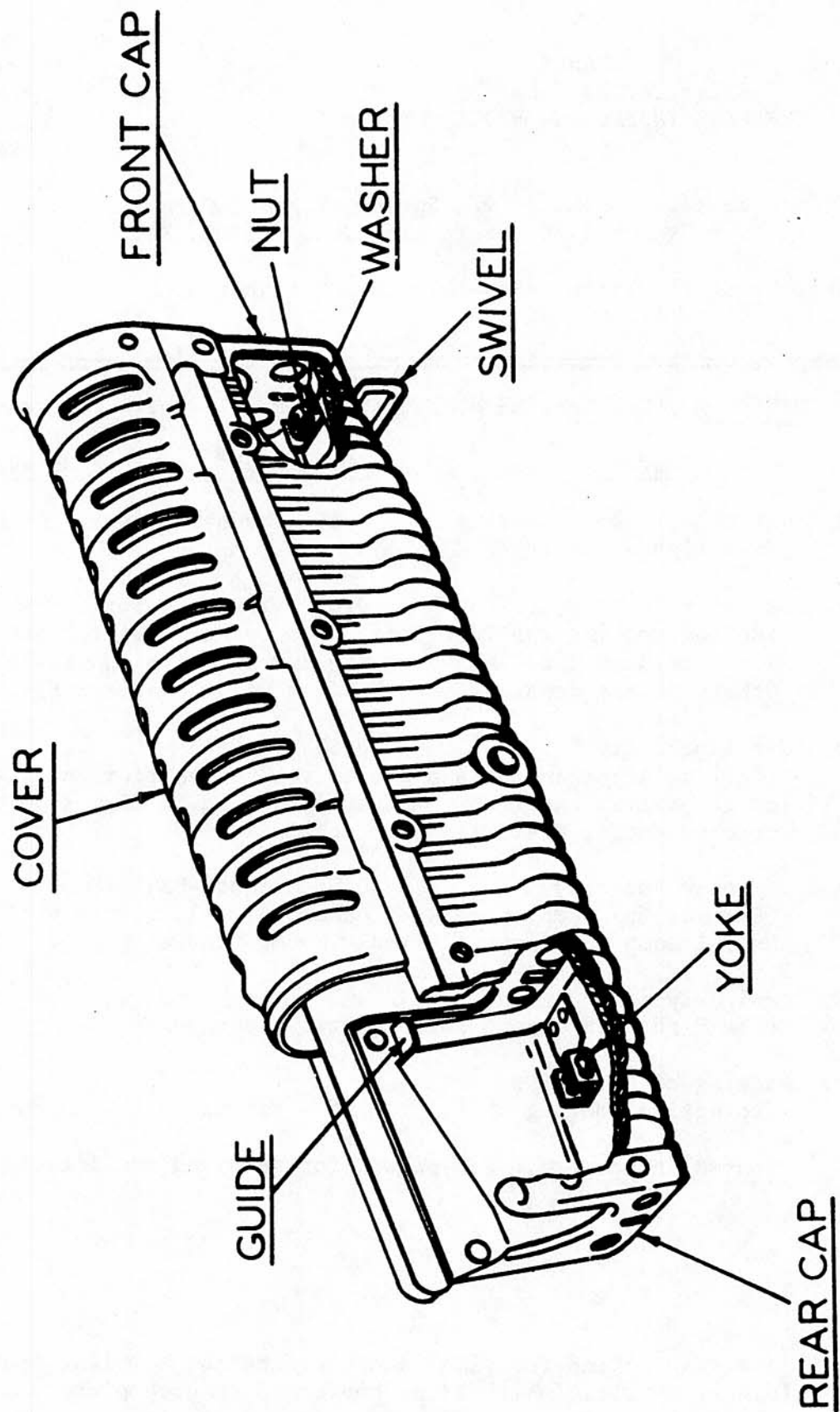
Important: Further Disassembly is not required

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

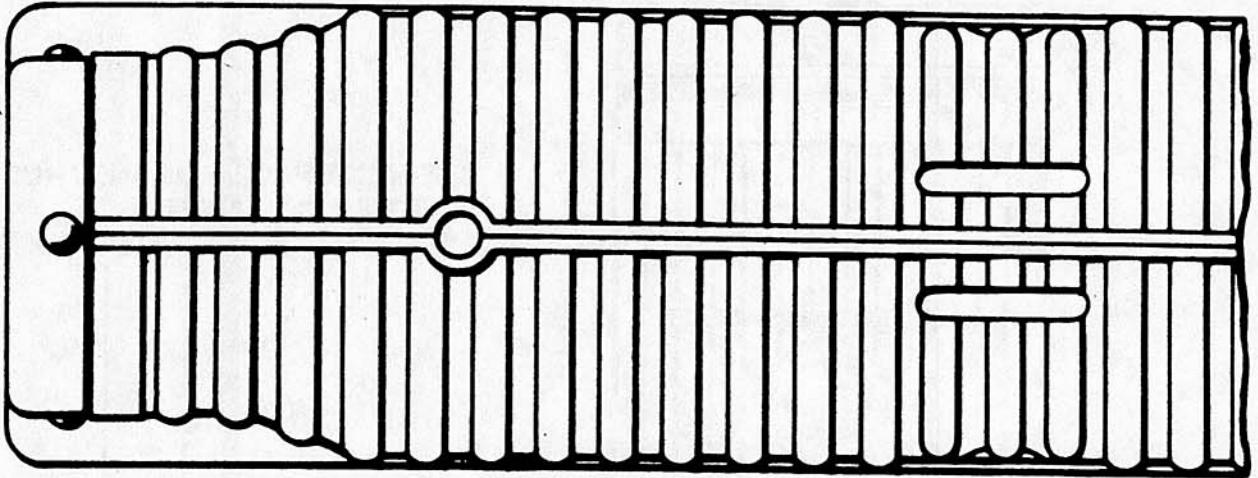
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Hardness, Rubber Coating (See figures on Pages 4 & 5)	0.65	Hardness Tester	45 Min.
2. Defective Rubber Coating (Rubber coating shall be free of tears and breaks. Surface mars, not exceeding 1/32 inch in depth and one inch in length are acceptable. Other surface scratches or scuffing will be acceptable.)	0.65	Visual-Measure	
3. Serviceability (Particular attention shall be given to the rear cap, yoke, guide, cover, swivel and front cap, as indicated in figure on page 2, for cracks, dents, distortions or mutilations.)	0.65	Visual	
4. Improper Assembly (Examine for completeness of assembly. All rivets shall be secure. Swivel loop shall swivel freely. See figure on page 2.)	0.65	Visual-Manual	
5. Design Type (See Figure on page 3 for acceptable design.)			
6. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

Process Inspection. See page 6 for required modification

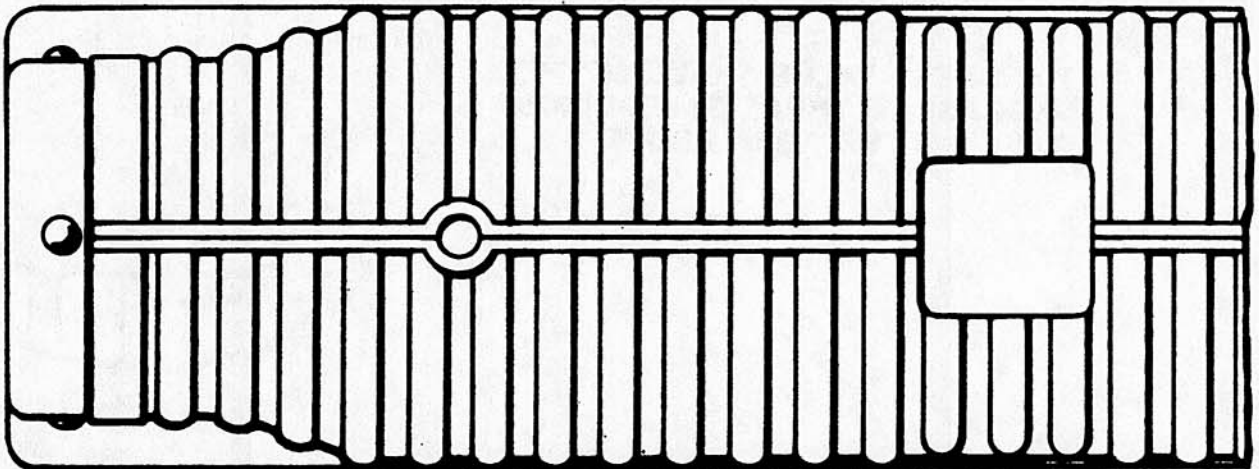
*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

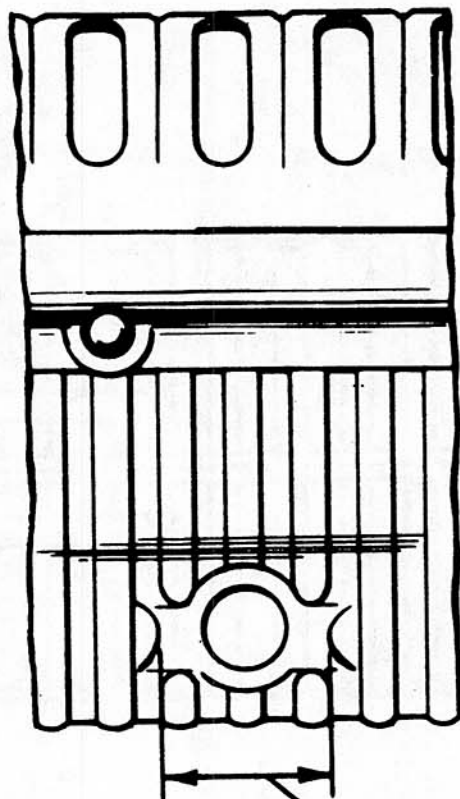


NOT ACCEPTABLE



ACCEPTABLE

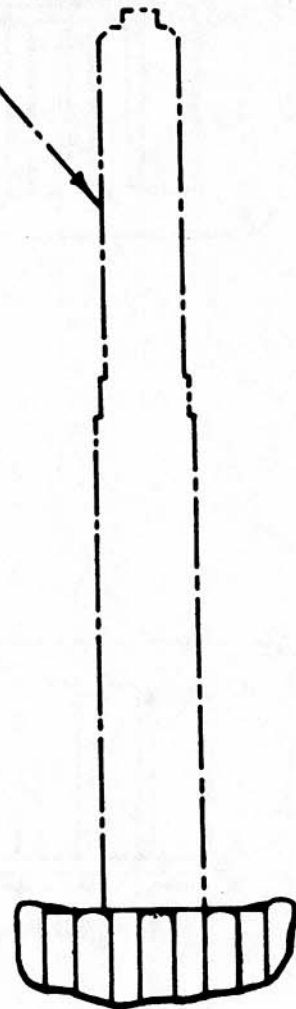




**HARDNESS
TEST AREA**

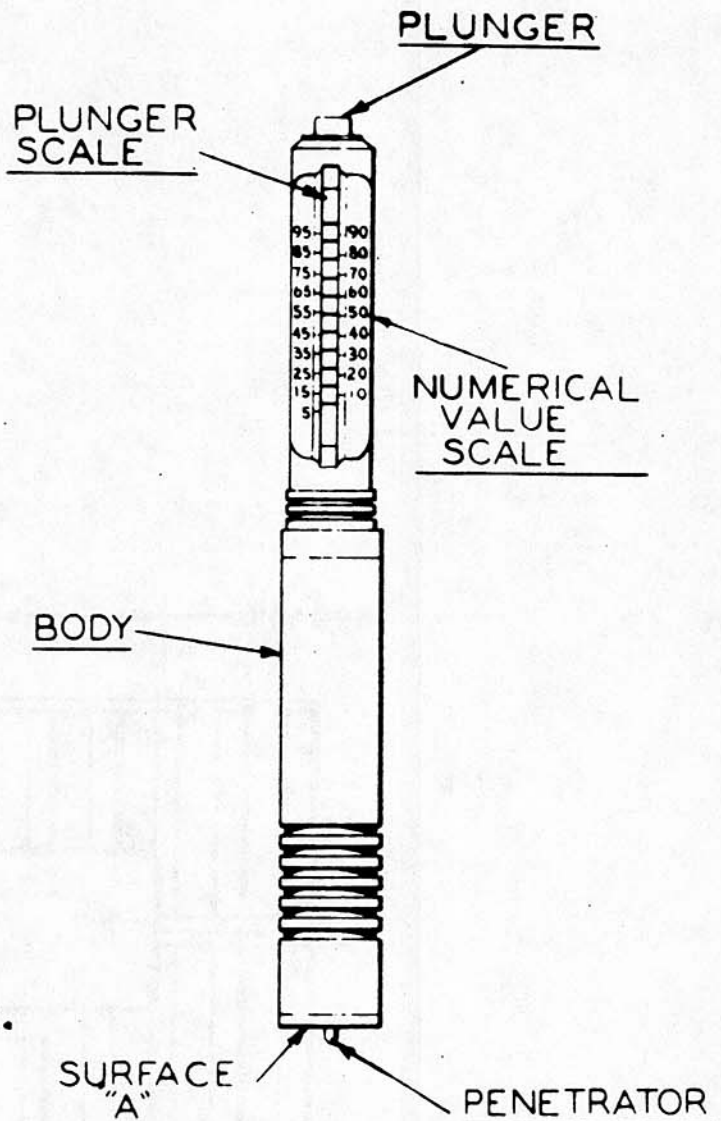
**HARDNESS VALUE SHALL BE THE
AVERAGE OF THREE (3) READINGS
TAKEN IN THE AREA ABOVE**

**SEE NEXT PAGE FOR INSTRUCTIONS
FOR USE OF TESTER**

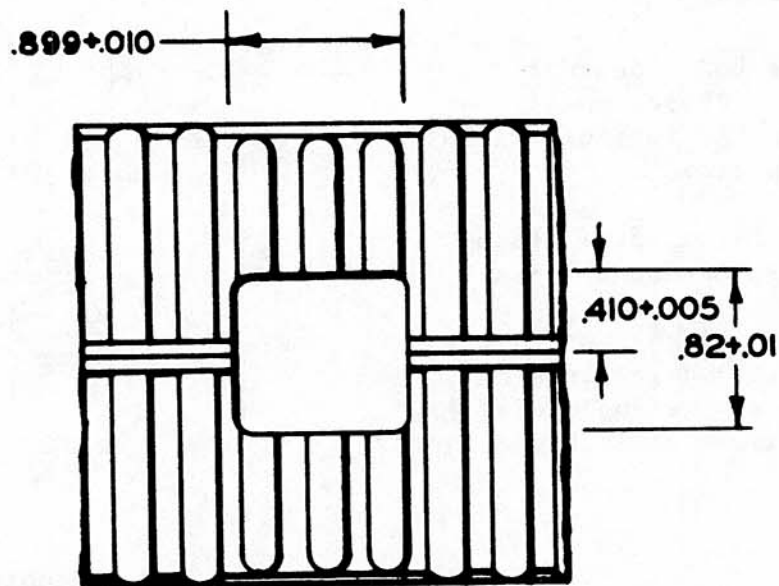


TEST INSTRUCTIONS

1. Prior to testing, assure that plunger is depressed.
2. Place penetrator on test piece, holding body perpendicular to test surface.
3. Holding body, depress hardness tester until surface "A" is flush with test surface.
4. Remove tester from piece and read hardness value.
5. Value shall be that number appearing where lines on numerical value scale and plunger scale are aligned.



Testing Machine Inc.
Mineola, New York
Rex Hardness Gauge
Model 1500
(Or approved equal)



NOTE: The Government representative shall conduct surveillance of the supplier's reconditioning operation for rejected components on Defect 5 to assure compliance with requirements depicted above.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269231
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

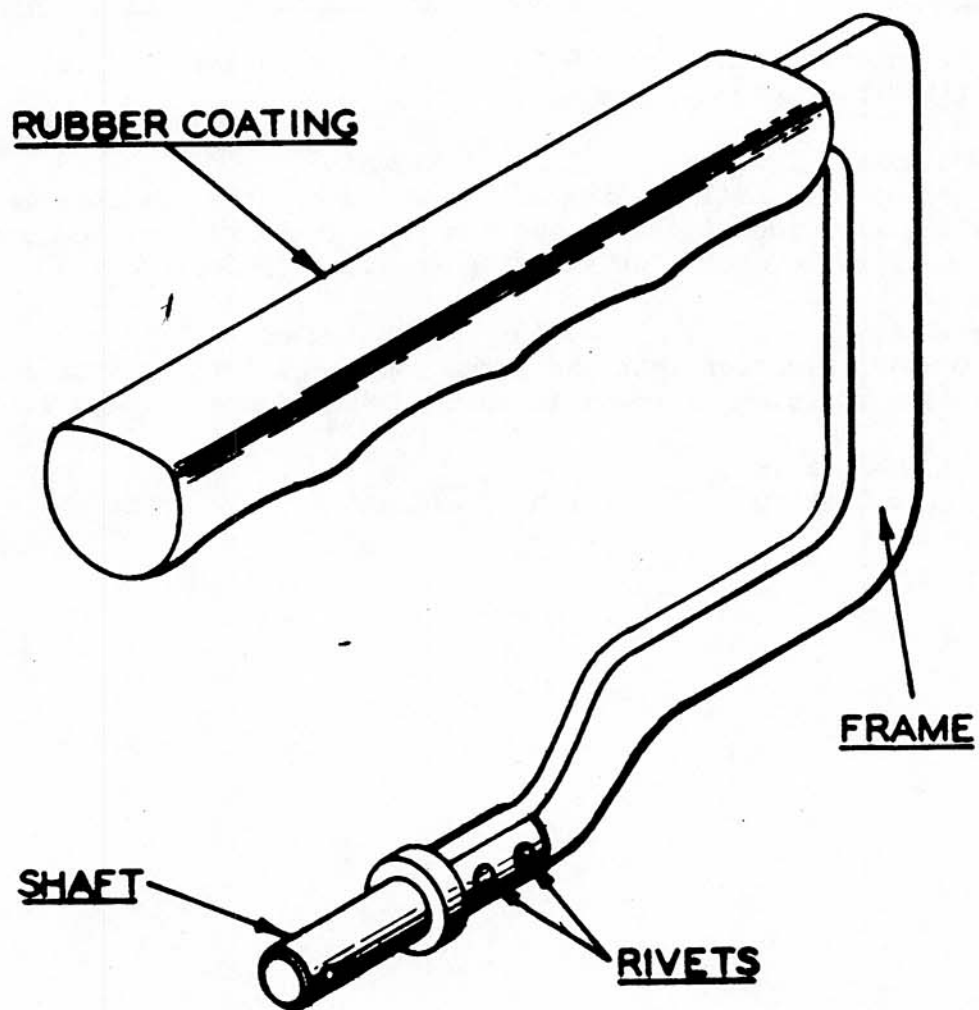
Item: Handle Assembly, Carrying
for Overhaul of the Machine Gun, 7.62MM, M60

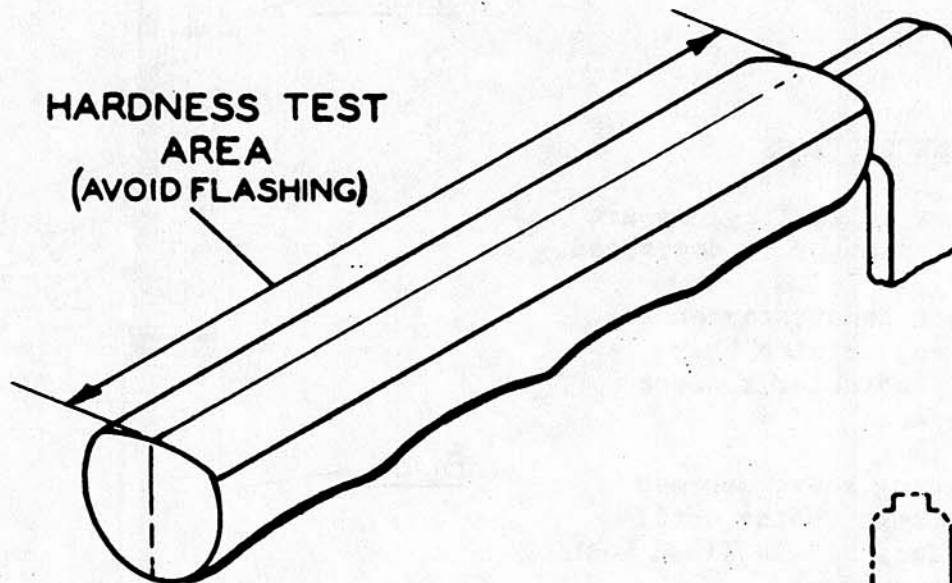
Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Hardness, Rubber Coating (See figures on pages 3 and 4)	0.65	Hardness Tester	45 Min.
2. Defective Rubber Coating (Rubber coating shall be free of tears and breaks. Surface mars not exceeding 1/32 inch in depth and one inch in length are acceptable. Other surface scratches or scuffing are acceptable.)	1.5	Visual	
3. Serviceability (Particular attention shall be given the frame for distortion and for secure riveting of frame to shaft. See figure on page 2.)	0.65	Visual-Manual	
4. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

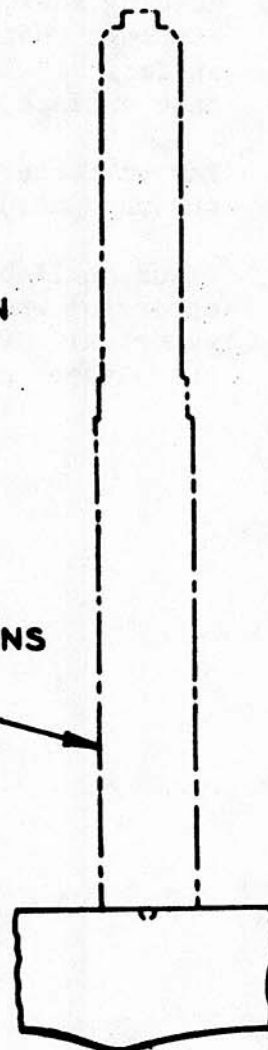
*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.





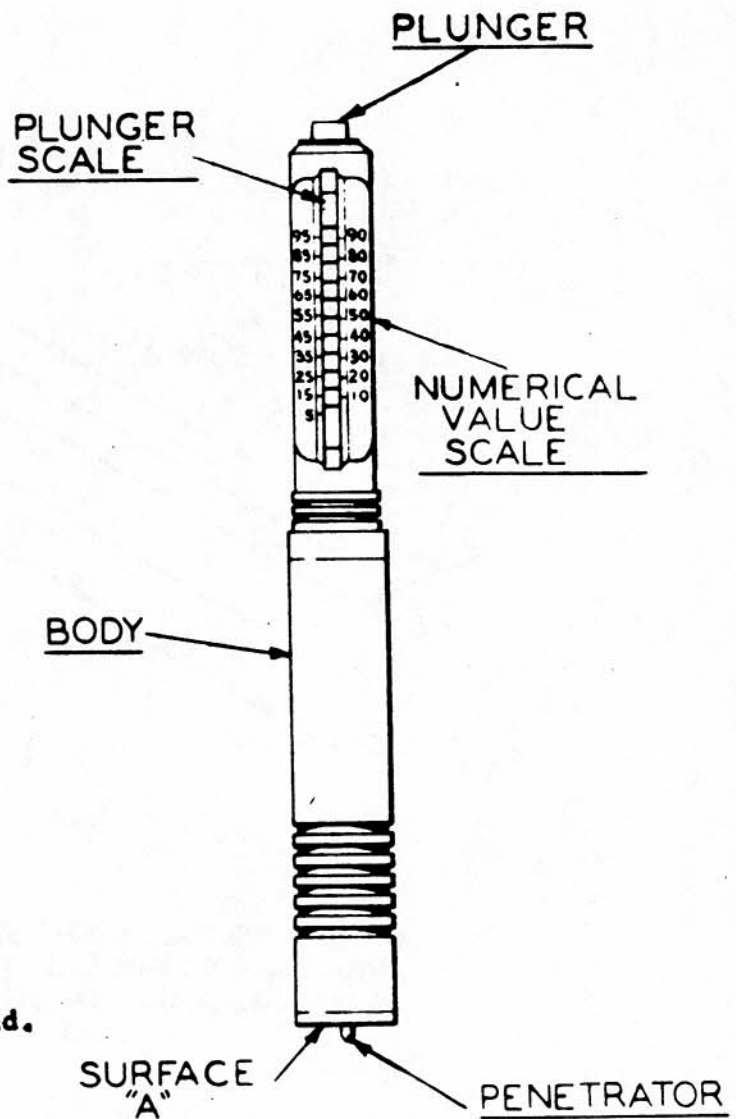
**HARDNESS VALUE SHALL BE THE
AVERAGE OF THREE (3) READINGS TAKEN
IN THE AREA INDICATED ABOVE**

**SEE NEXT PAGE FOR INSTRUCTIONS
FOR USE OF TESTER**



TEST INSTRUCTIONS

1. Prior to testing, assure that plunger is depressed.
2. Place penetrator on test piece, holding body perpendicular to test surface.
3. Holding body, depress hardness tester until surface "A" is flush with test surface.
4. Remove tester from piece and read hardness value.
5. Value shall be that number appearing where lines on numerical value scale and plunger scale are aligned.



Testing Machine Inc.
Mineola, New York
Rex Hardness Gauge
Model 1500
(Or approved equal)

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269056
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

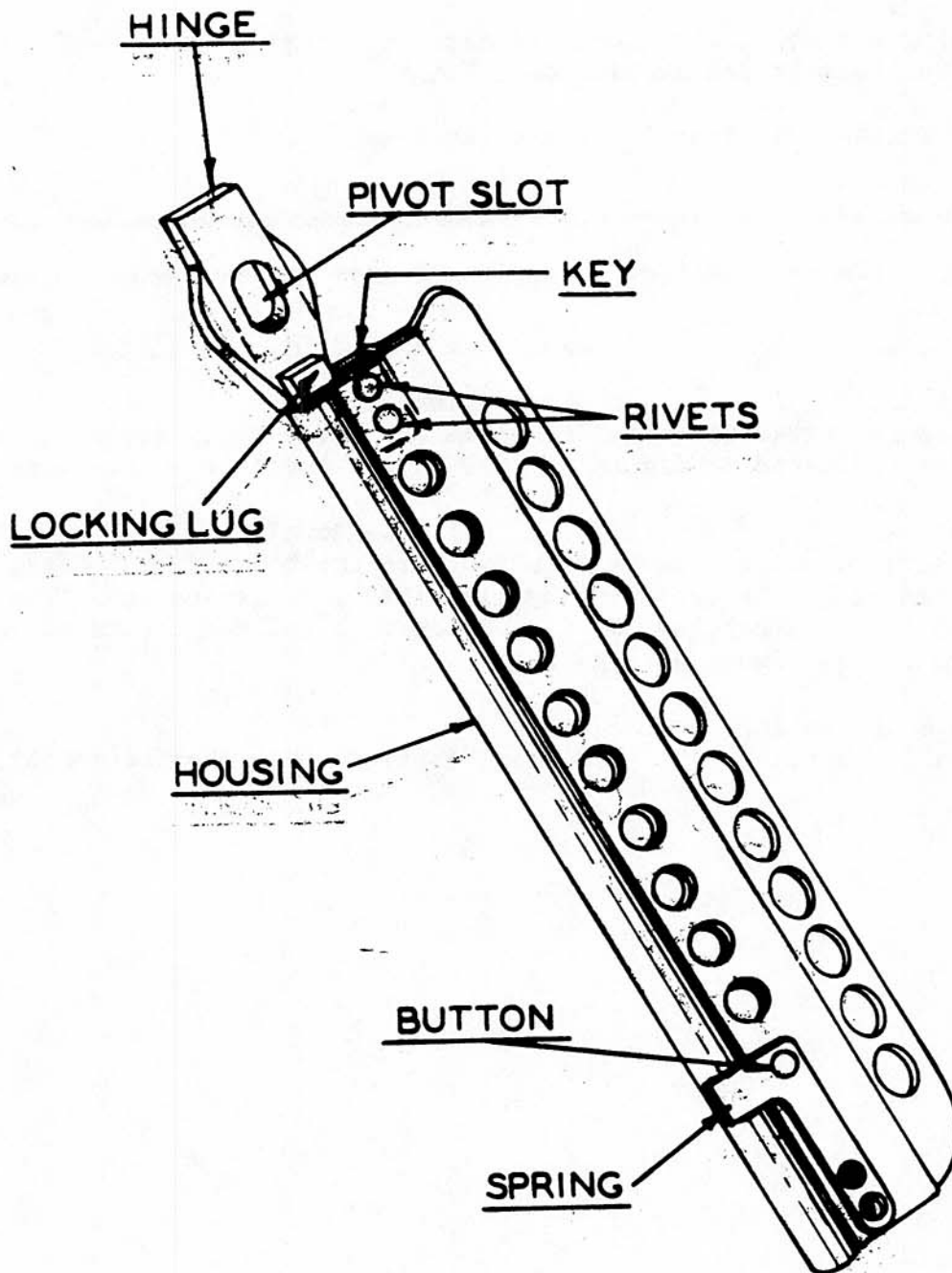
Item: Housing Assembly, Foot, L.H. w/Button and Spring
for Overhaul of the Machine Gun, 7.62MM, M60

Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pivot slot and the locking lug, as indicated in figure on page 2, for burrs or mutilations.)	0.65	Visual	
2. Improper Assembly (The hinge shall be securely retained to the housing by brazing and the riveted key as evidenced by visual-manual examination. The spring shall be retained by the button with the two rivets and key removed. See figure on page 2.)	0.65	Visual-Manual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269062
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Housing Assembly, Foot, R.H. w/Button and Spring
for Overhaul of the Machine Gun, 7.62MM, M60

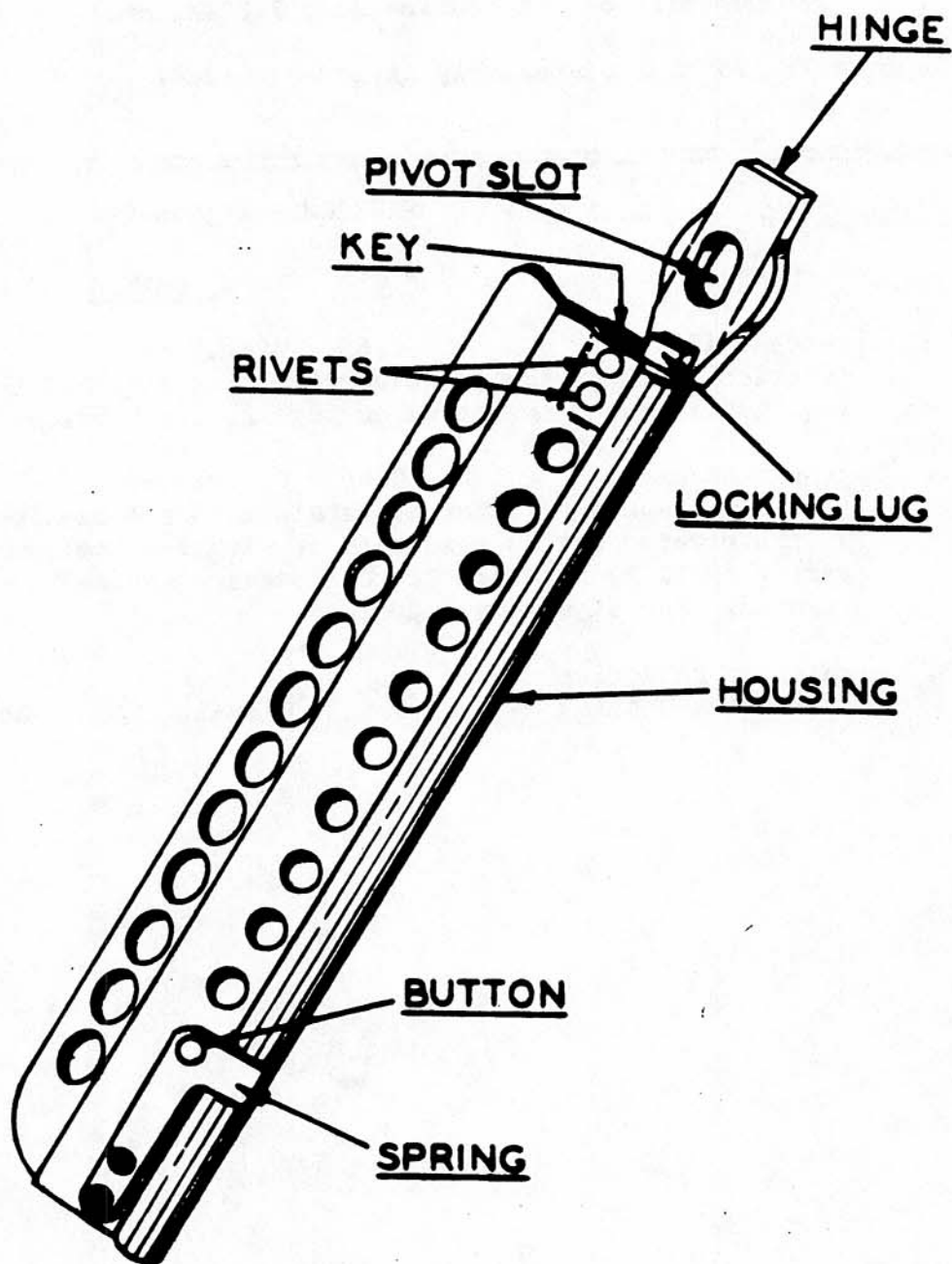
Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pivot slot and the locking lug, as indicated in figure on page 2, for burrs or mutilations.)	0.65	Visual	
2. Improper Assembly (The hinge shall be securely retained to the housing by brazing and by the riveted key as evidenced by visual-manual examination. The spring shall be retained by the button with the two rivets and key removed. See figure on page 2.)	0.65	Visual-Manual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

DQA LIBRARY

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269203
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

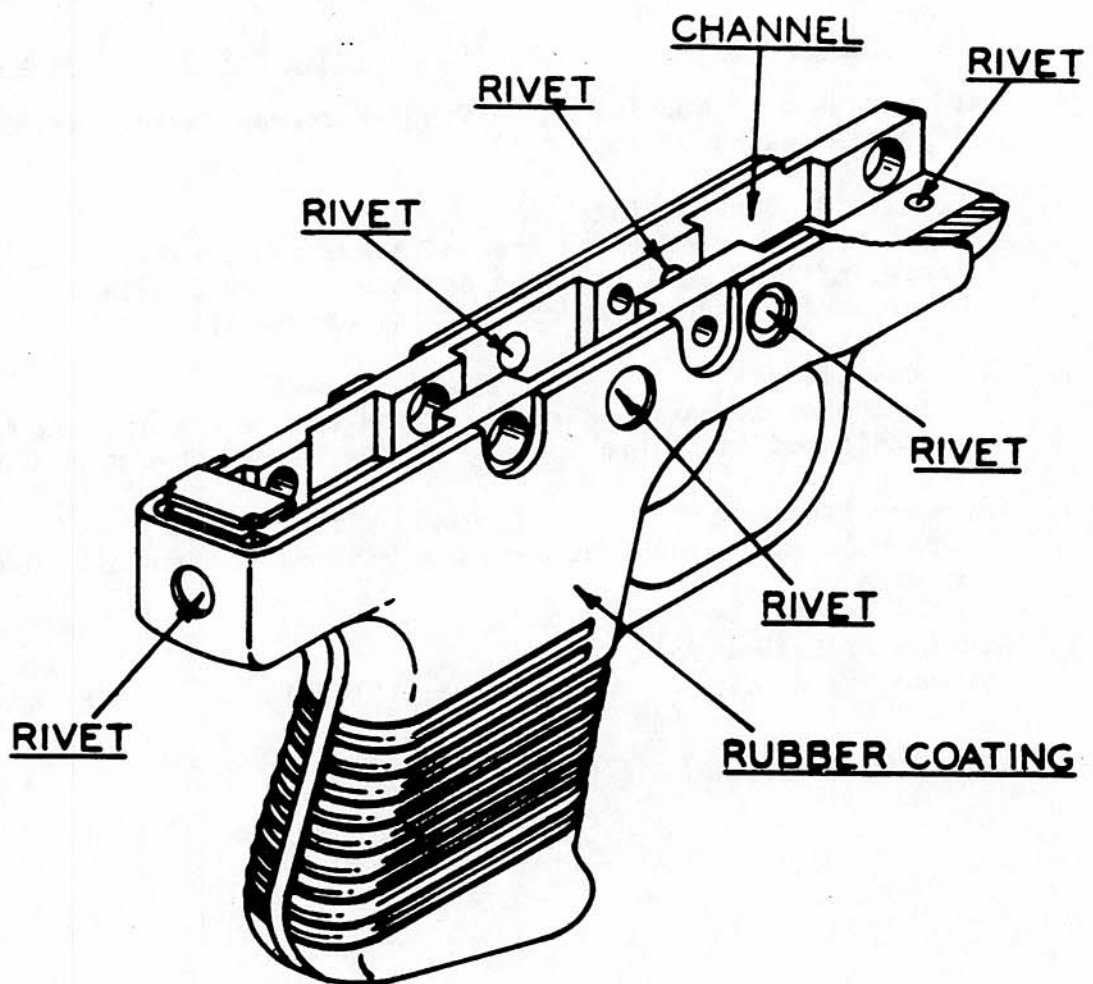
Item: Housing Assembly, Trigger
for Overhaul of the Machine Gun, 7.62MM, M60

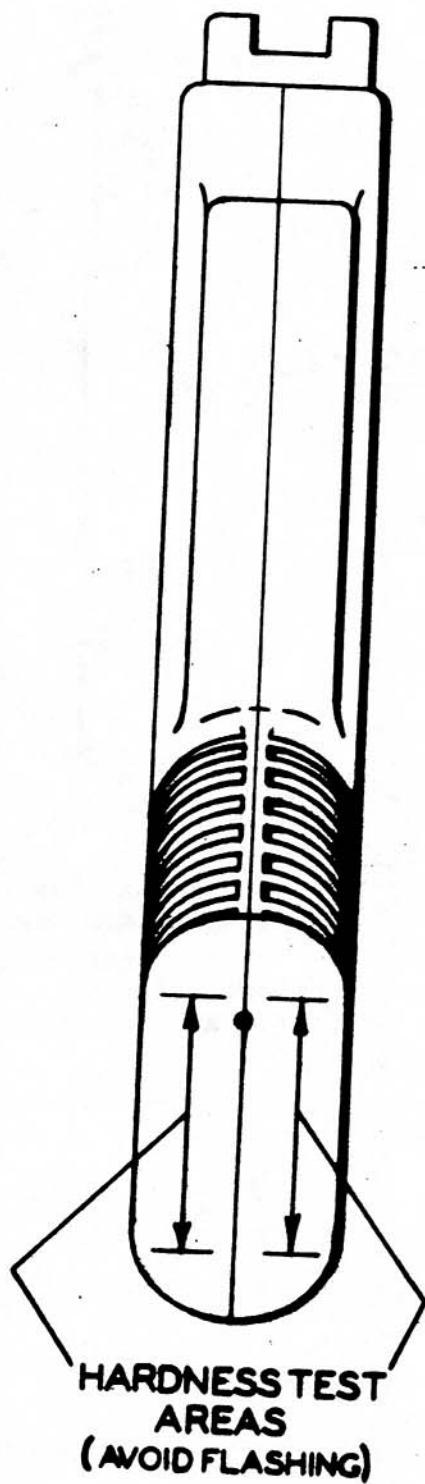
Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

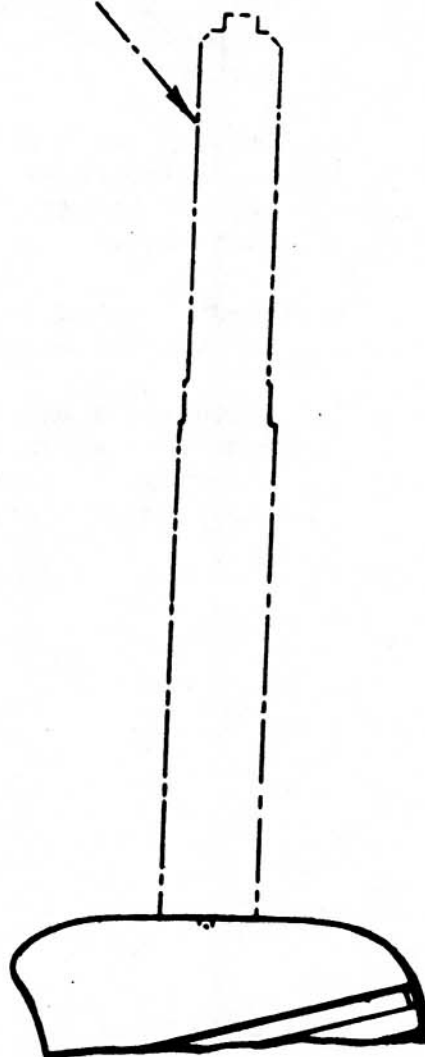
<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Hardness, Rubber Coating (See figures on pages 3 & 4)	0.65	Hardness Tester	45 Min.
2. Defective Rubber Coating (Rubber coating shall be free of tears and breaks. Surface mars not exceeding 1/32 inch in depth and one inch in length are acceptable. Other surface scratches or scuffing are acceptable.)			
3. Serviceability (Particular attention shall be given to the channel and frame areas, as indicated in figure on page 2, for burrs, cracks or mutilations.)	0.65	Visual	
4. Improper Assembly (Frame assembly shall be securely riveted to channel. See figure on page 2.)	0.65	Visual-Manual	
5. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

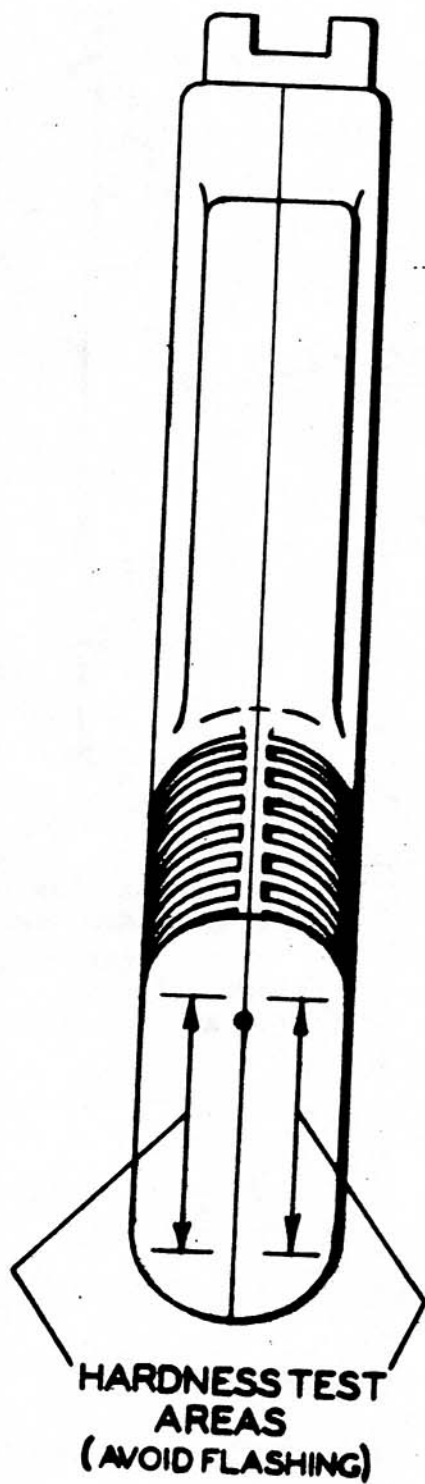




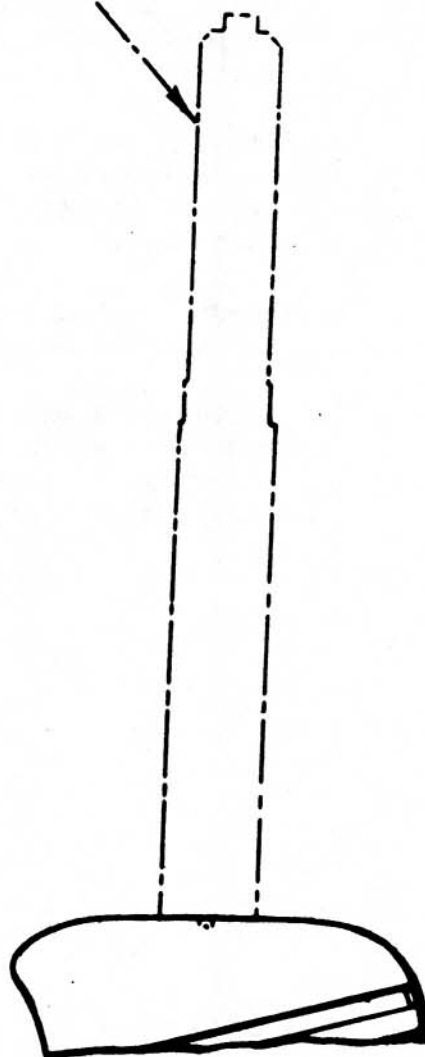
SEE NEXT PAGE FOR INSTRUCTIONS
FOR USE OF TESTER



**HARDNESS VALUE SHALL BE THE
AVERAGE OF THREE (3) READINGS TAKEN
IN THE AREAS INDICATED ABOVE.**



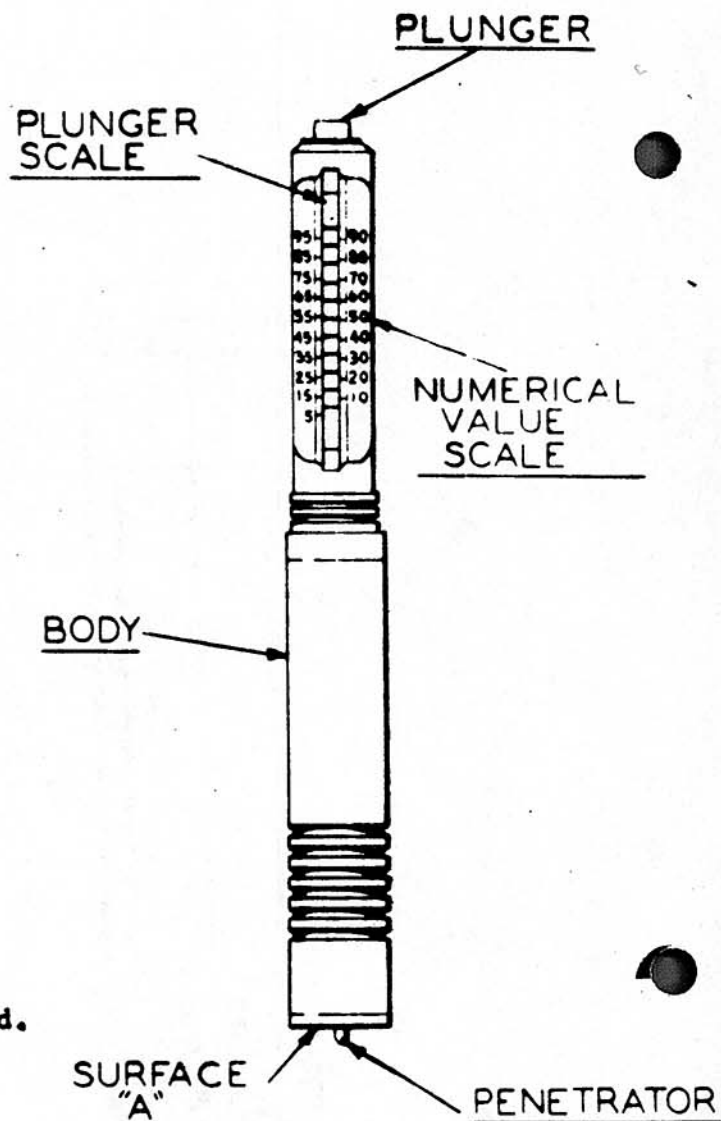
SEE NEXT PAGE FOR INSTRUCTIONS
FOR USE OF TESTER



**HARDNESS VALUE SHALL BE THE
AVERAGE OF THREE (3) READINGS TAKEN
IN THE AREAS INDICATED ABOVE.**

TEST INSTRUCTIONS

1. Prior to testing, assure that plunger is depressed.
2. Place penetrator on test piece, holding body perpendicular to test surface.
3. Holding body, depress hardness tester until surface "A" is flush with test surface.
4. Remove tester from piece and read hardness value.
5. Value shall be that number appearing where lines on numerical value scale and plunger scale are aligned.



Testing Machine Inc.
Mineola, New York
Rex Hardness Gauge
Model 1500
(Or approved equal)

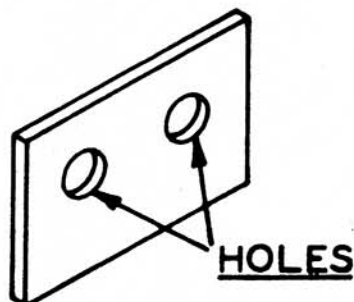
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269057
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Key, Guide, Foot
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given holes, as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURES
for

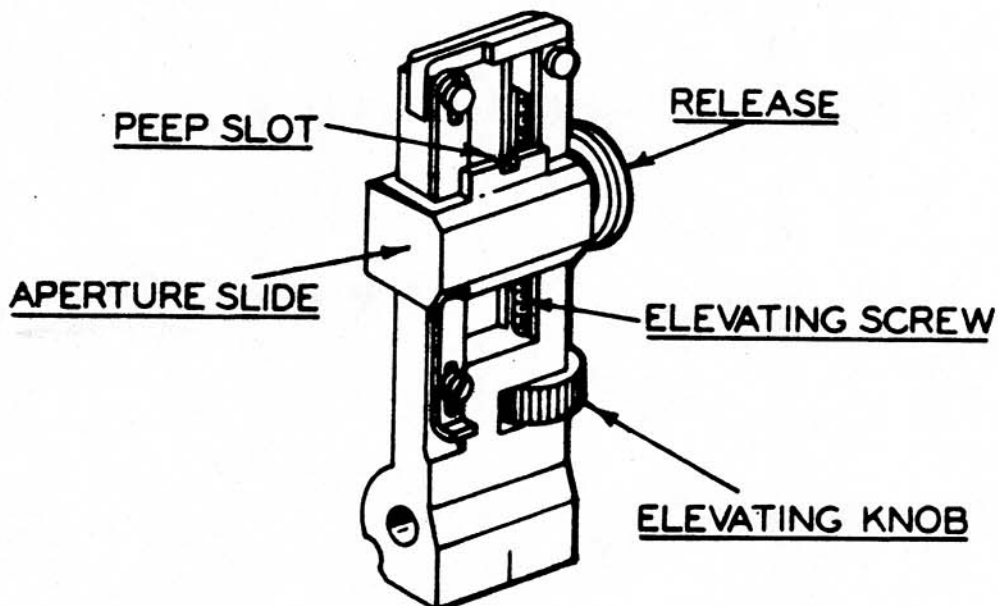
OIP-7269279
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Leaf Assembly, Rear Sight
for Overhaul of the Machine Gun, 7.62MM, M60

Important: Further disassembly is not required

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp.Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the peep slot for burrs or deformations as indicated in the figure below.)	0.65	Visual	
2. Improper Assembly (When elevation knob is rotated, the elevating screw will move the aperture slide through its full range of travel and shall produce audibly perceptible clicks. When release is depressed, the slide shall move freely and when pressure is removed from release, the slide shall lock in place. See figure below.)	0.65	Visual-Manual	
3. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

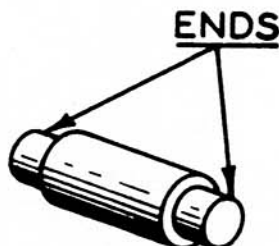
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269184
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Catch, Forearm
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given ends, as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

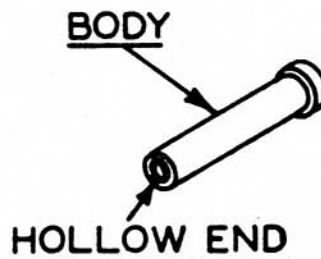
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269246
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Handle
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the body, as indicated in figure below, for burrs or mutilations. Slight loss of metal, on hollow end, due to previous staking is permissible.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



Carrying Handle

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

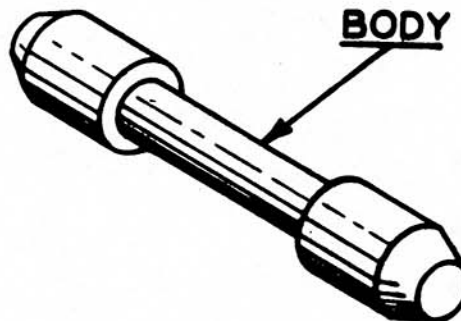
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269048
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Retainer, Spring
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the body as indicated in figure below for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

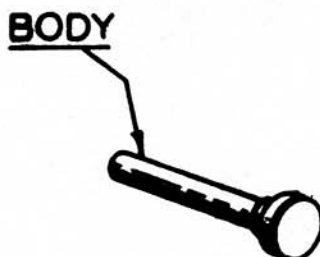
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269204
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Pin, Trigger
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to body, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269250
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plunger, Carrying Handle
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the locking end, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

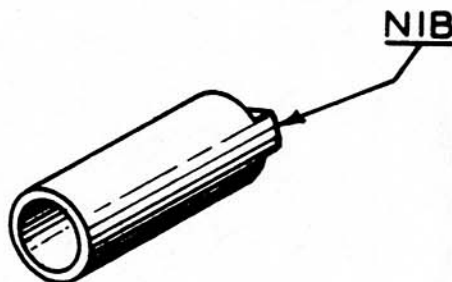
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269206
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plunger, Safety
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the nib, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269050
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Plunger, Spring, Leg
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the head, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U.S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269053
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Retainer, Spring Leg
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pin hole, as indicated in the figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

PIN HOLE



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP - 7269267
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Ring, Handle Retaining
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pin hole, as indicated in the figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

PIN HOLE



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7790800
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Ring, Snap
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pin opening, as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

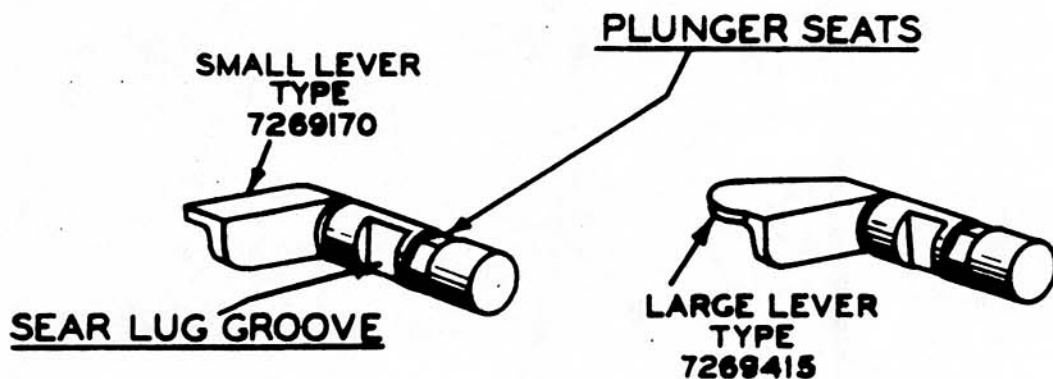
OIP - 7269415
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Safety
for overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the plunger seats and sear lug groove as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

NOTE: Both designs shown in figure below are acceptable.



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

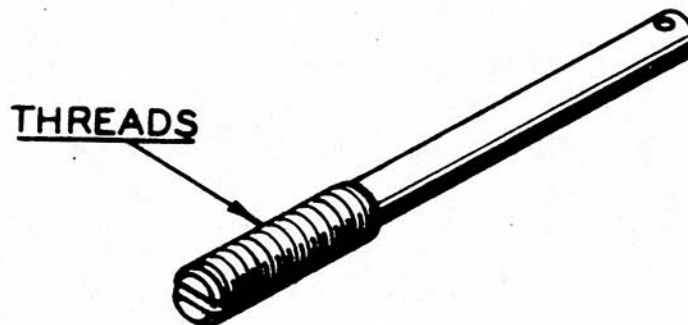
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269281
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Screw, Windage
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the threads, as indicated in figure below, for burrs and mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

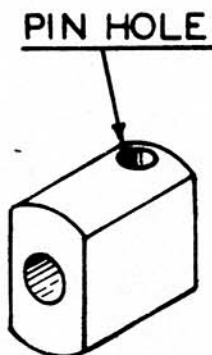
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269282
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Slide, Screw
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the pin hole, as indicated in the figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

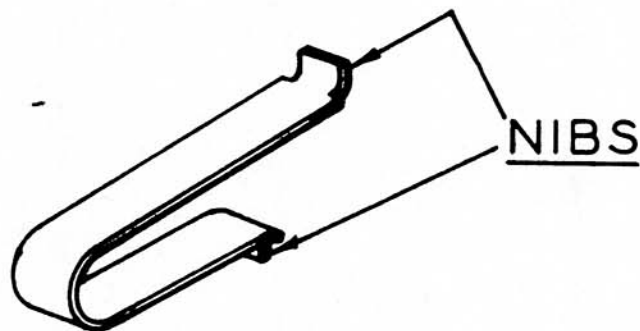
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269187
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Catch Forearm
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the nibs, as indicated in figure below for cracks, burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Black Oxide Coating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269052
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Bipod Assembly)
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for length and proper ends, as indicated in figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be free of foreign matter.



MIN. LENGTH
.855

COMPARISON GAGE
Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269210
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Safety, Plunger)
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION: See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to springs for length and proper ends, as indicated in figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be clean and free of foreign matter.



MIN. LENGTH ————
.590

COMPARISON GAGE

Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

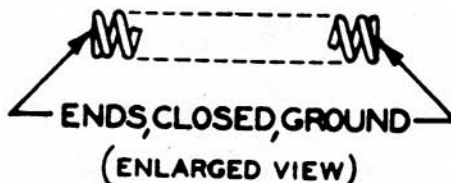
OIP-7269283
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical, Compression (use with Base Rear Sight)
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for length and proper ends as indicated in figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be clean and free of foreign matter.



COMPARISON GAGE
Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

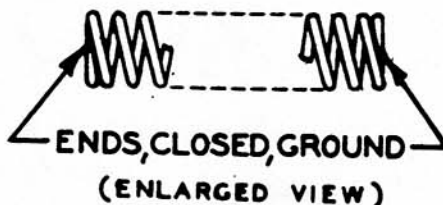
OIP-7269302
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Spring, Helical Compression (use with Carrying Handle)
for Overhaul of the Machine Gun, 7.62MM, M60

EXAMINATION. See Section 4 of USAWECOMDMWI 1005- 224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to spring for length and proper ends, as indicated in figure below.)	0.65	Visual	

NOTE: Springs shall be considered acceptable with or without black oxide coating and shall be clean and free of foreign matter.



COMPARISON GAGE
Use to determine length of questionable springs.
Component must not come within tolerance zone indicated.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7269304
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

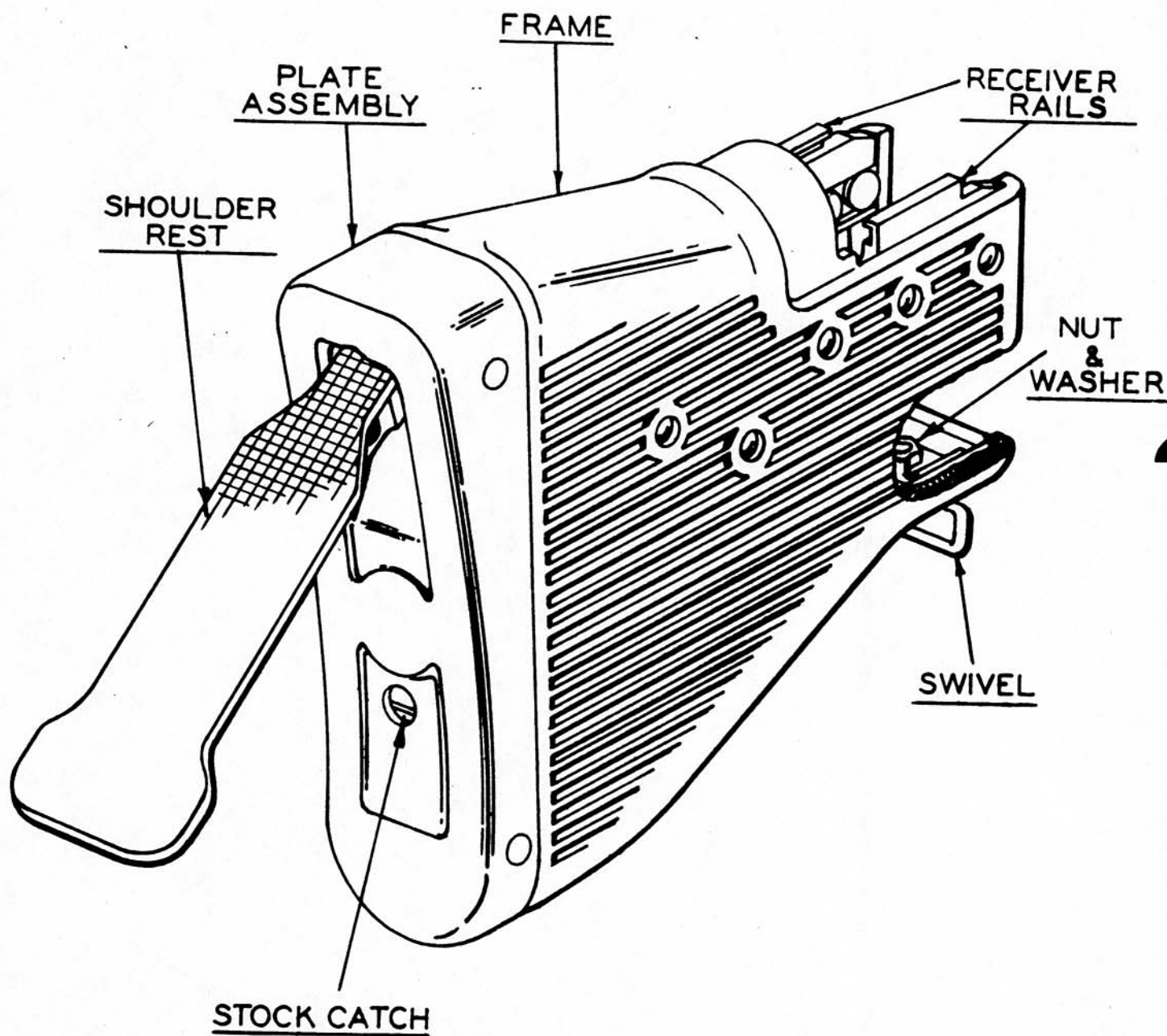
Item: Stock Assembly, Butt
for Overhaul of the Machine Gun, 7.62MM, M60

Important: Further disassembly is not required.

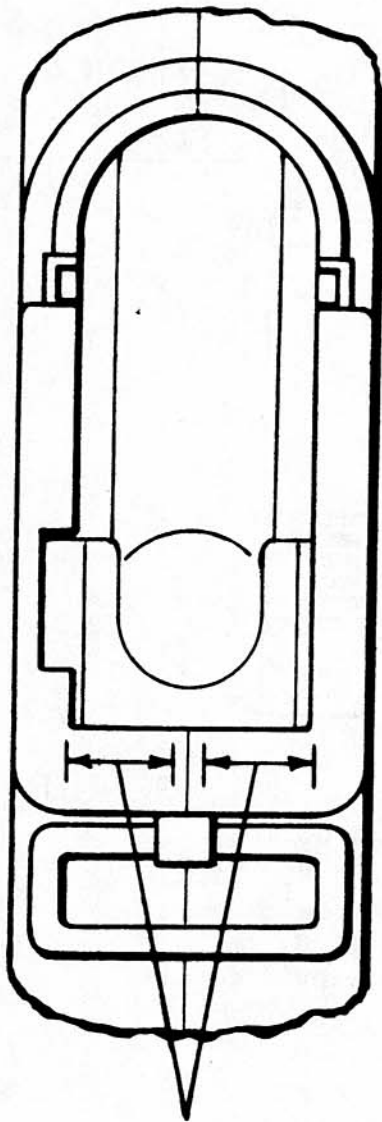
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Hardness, Rubber Coating (See Figures on pages 3 and 4)	0.65	Hardness Tester	45 Min.
2. Defective Rubber Coating (Rubber coating shall be free of tears and breaks. Surface mars not exceeding 1/32 inch in depth and one inch in length are acceptable. Other surface scratches or scuffing are acceptable.)	0.65	Visual	
3. Serviceability (Particular attention shall be given to butt stock frame and receiver rails, as indicated in figure on page 2, for dents or mutilations and to rivet retention of the plate assembly to frame assembly. The shoulder rest shall not be used as a lever in examining retention of plate assembly.)	0.65	Visual-Manual	
4. Improper Assembly (Loop or swivel shall pivot freely. Nut must be locked by swivel washer. Shoulder rest plate shall be held by action of the spring and plunger, in both the closed and extended position stock catch shell function under spring tension.)	0.65	Visual-Manual	
5. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

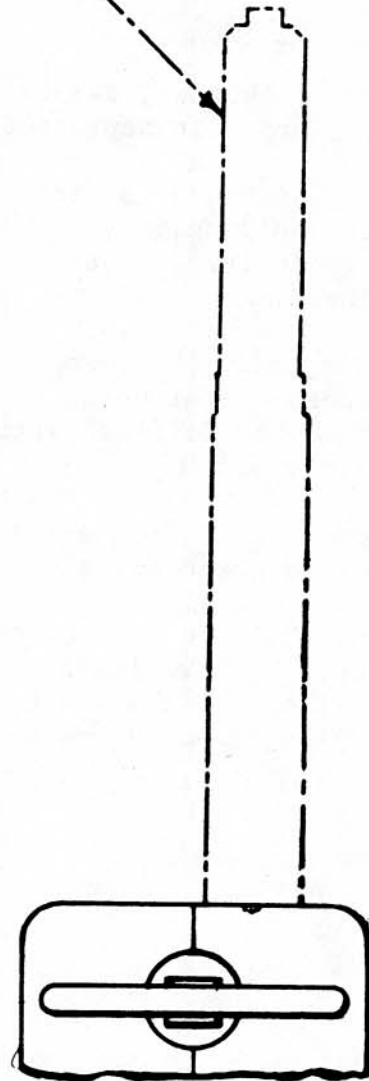
*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



SEE NEXT PAGE FOR INSTRUCTIONS
FOR USE OF TESTER



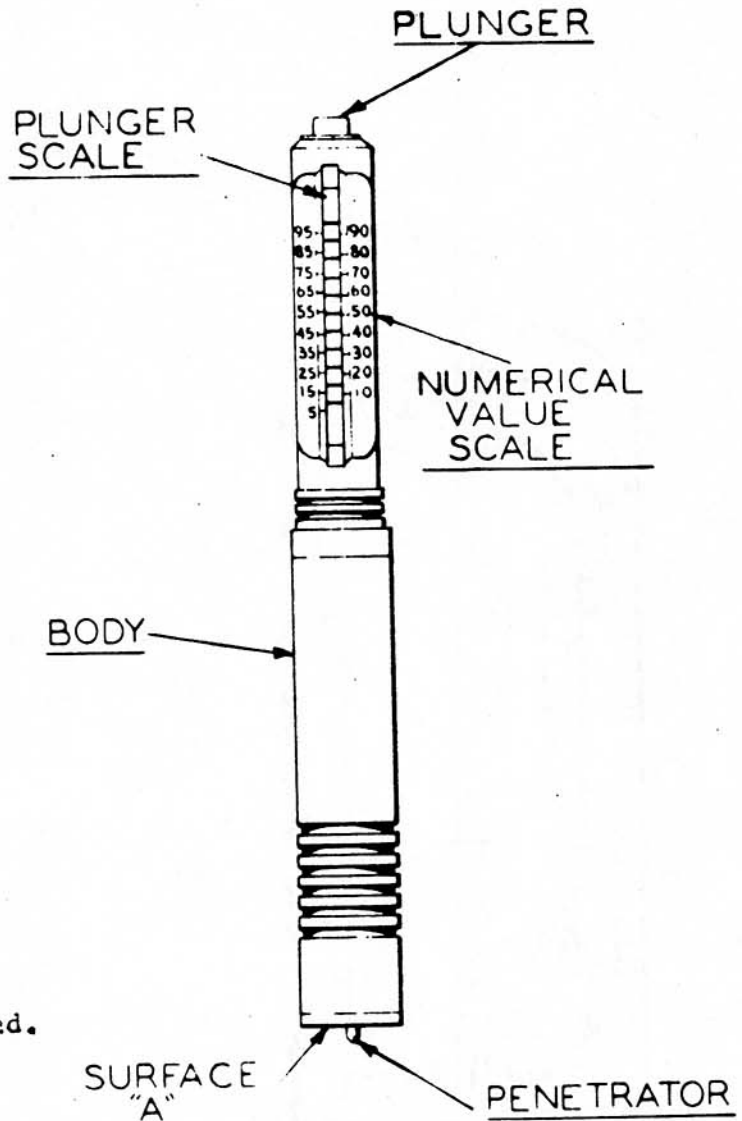
HARDNESS TEST
AREAS
(AVOID FLASHING)



HARDNESS VALUE SHALL BE THE
AVERAGE OF THREE (3) READINGS TAKEN
IN THE AREAS INDICATED ABOVE.

TEST INSTRUCTIONS

1. Prior to testing, assure that plunger is depressed.
2. Place penetrator on test piece, holding body perpendicular to test surface.
3. Holding body, depress hardness tester until surface "A" is flush with test surface.
4. Remove tester from piece and read hardness value.
5. Value shall be that number appearing where lines on numerical value scale and plunger scale are aligned.



Testing Machine Inc.
Mineola, New York
Rex Hardness Gauge
Model 1500
(Or approved equal)

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

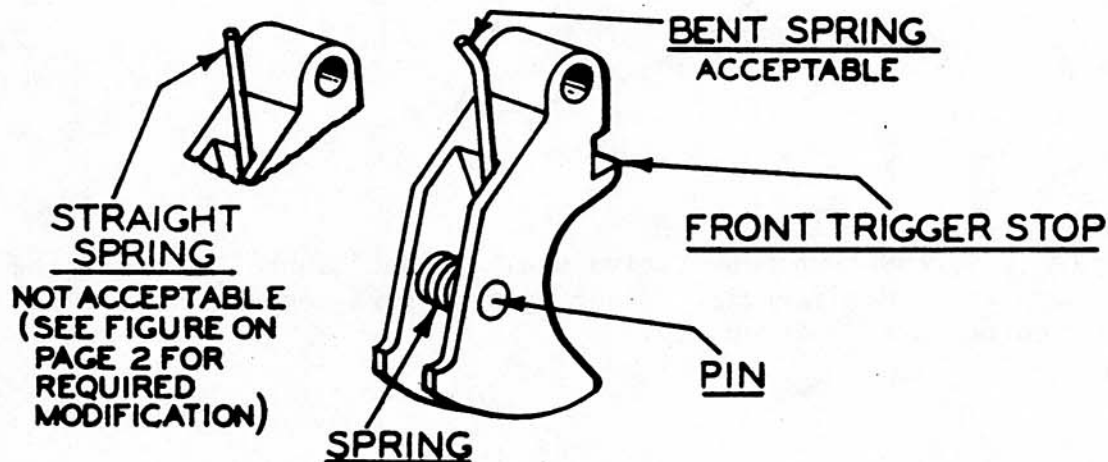
OIP-7269212
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Trigger Assembly
for Overhaul of the Machine Gun, 7.62MM, M60

Important: Further disassembly is not required

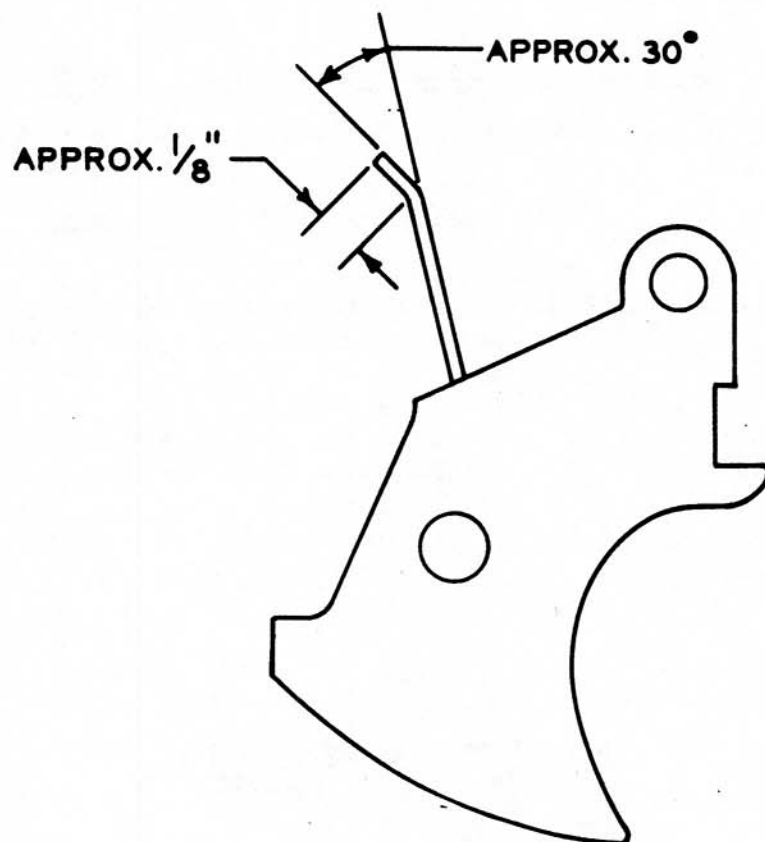
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the spring and front trigger stop, as indicated in figure below, for mutilations or breaks.)	0.65	Visual	
2. Improper Assembly (Examine for completeness of assembly, pin, spring and trigger. Pin must be riveted securely. See figure below.)	0.65	Visual-Manual	
3. Improper Spring Modification (See figure below.)	0.65	Visual	
4. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating



PROCESS INSPECTION. See page 2 for required modification.

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



NOTE: The Government representative shall conduct surveillance of the supplier's modification of spring to assure compliance with requirements depicted above.

PART IV

INDEX OF OVERHAUL INSPECTION PROCEDURES
APPLICABLE ONLY TO
Machine Gun 7.62MM, M60C
(To be used in addition to OIP's in Part II)

<u>OIP NUMBER</u>	<u>NOMENCLATURE DESCRIPTION</u>
7792074	Backplate Assembly
7792084	Barrel Subassembly
7792095	Bolt, Machine, Aircraft
7792092	Clamp, Rim Clenching
7792091	Housing, Solenoid
7791685	Solenoid

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

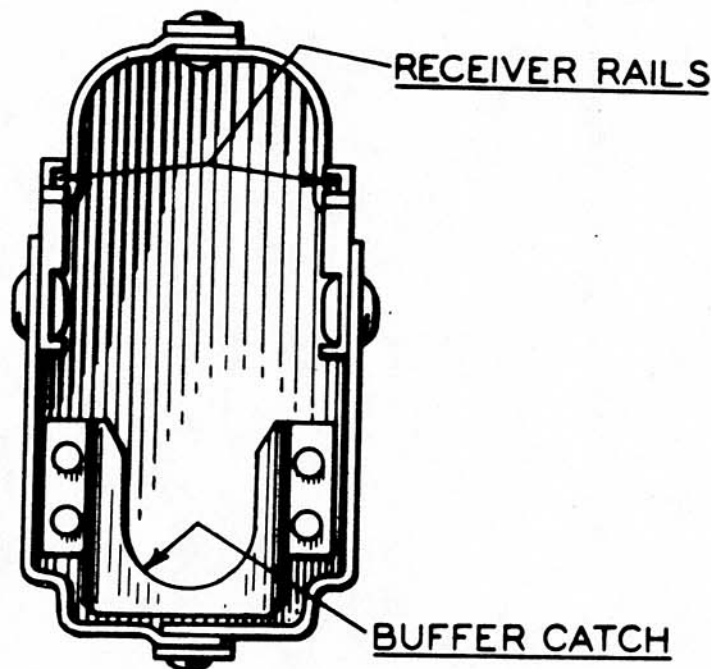
OIP-7792074
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Backplate Assembly
for Overhaul of the Machine Gun, 7.62MM, M60C

Important: Further disassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the buffer catch and receiver rails for burrs or mutilations and to assure secureness of riveting. Minor dents remaining after reconditioning will be permissible providing they do not interfere with assembleability and retention.)	0.65	Visual Manual	
2. Missing or Defective Protective Coating	1.5	Visual	Anodic Coating



*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7792084
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Barrel Subassembly
for Overhaul of the Machine Gun, 7.62MM, M60C

Important: Further dissassembly is not required.

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular Attention shall be given to the areas noted below and depicted in figure on page 3.)	0.65	Visual-Manual	
a. Flash Suppressor for cracks, burrs or mutilations.			
b. Gas Cylinder, (check serrations both ends for wear that would adversely affect retention of nut and extension, secureness of cylinder to barrel as determined by hand test, and diameter of piston hole for visible dents.)			
c. Socket, for cracks in bolt locking area.			
2. Headspace, Over	0.65	7799754 And Standard Dial Depth Gage (See figure on page 4)	1.638 Max.
3. Bore and Chamber	0.65	Visual	
a. Barrels will be straight as determined visually.			
b. Bore and chamber must be clean and free of corrosion.			
c. Pits as wide as a land or groove and three-eighths inch or less in length are allowable. Pits are exceeding this acceptance criteria shall be cause for rejection.			
d. Scattered or uniformly fine pits or fine pits in a densely pitted are are allowable.			
e. Tool marks or scratches are acceptable regardless of length. Tool marks will appear as lines running laterally in the grooves or may run spirally across the top of the lands.			

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
f. Definitely ringed bores or bores ringed sufficiently to bulge the outside surface of the barrel are cause for rejection. Faint rings or shadowy depressions do not indicate an unserviceable barrel and should not be cause for rejection. g. Lands that appear dark due to coating of gilding metal from projectiles should not be cause for rejection. h. Stripped or flaked plating in the bore shall be cause for rejection. i. Particular attention shall be given area of liner just forward of bullet seat for chipping.			
4. Diameter, Gas Port Hole, Under	0.65	A7799757 (See figure on page 5)	
5. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating (Bore and chamber shall be free of protective coating.)

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

**U.S. ARMY WEAPONS COMMAND
DEPOT MAINTENANCE WORK INSTRUCTIONS
FOR**

Overhaul Of The Machine Guns, 7.62MM:

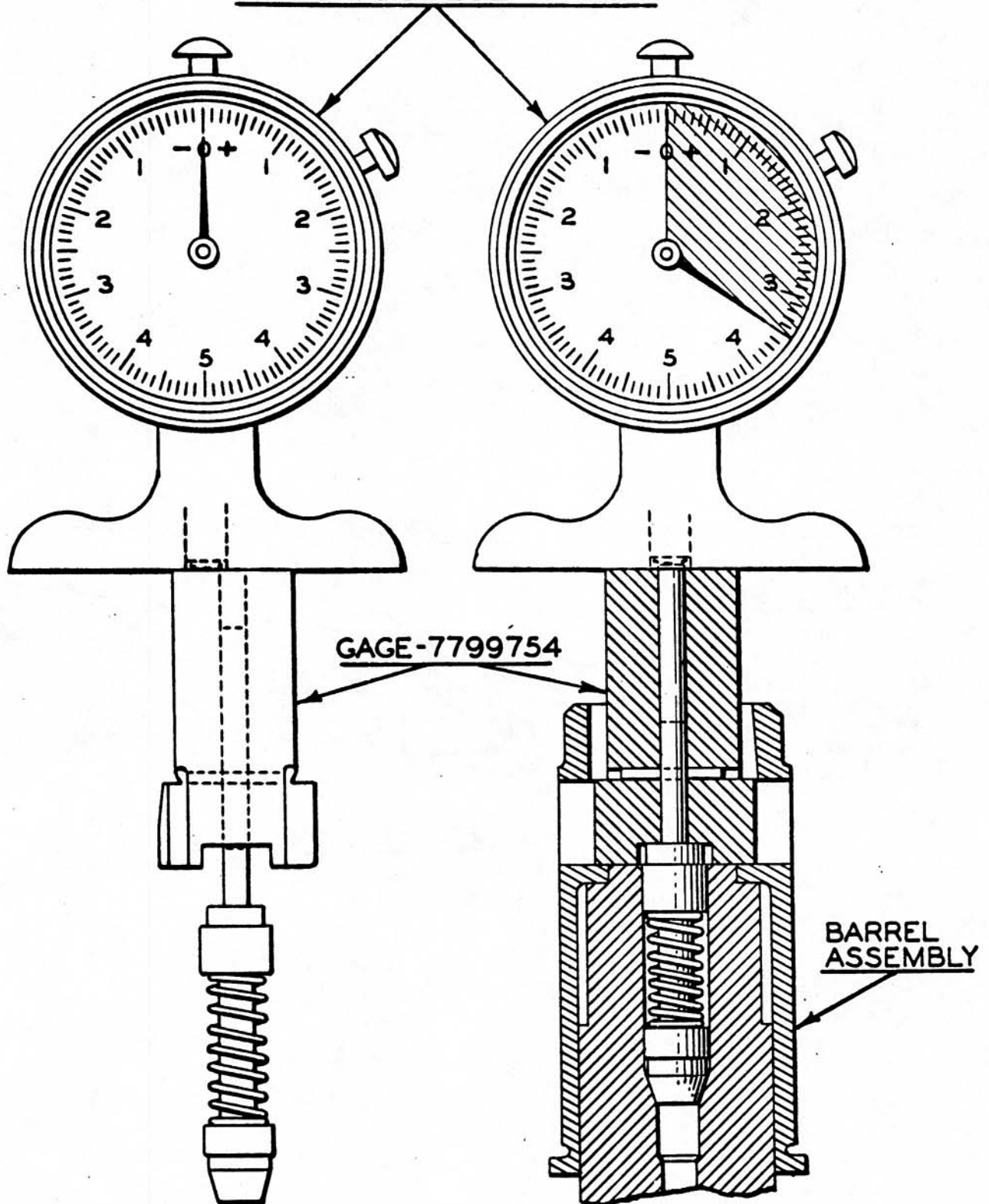
M60 And M60C



LIBRARY COPY
630 OCT 15 1965

MAY 1965

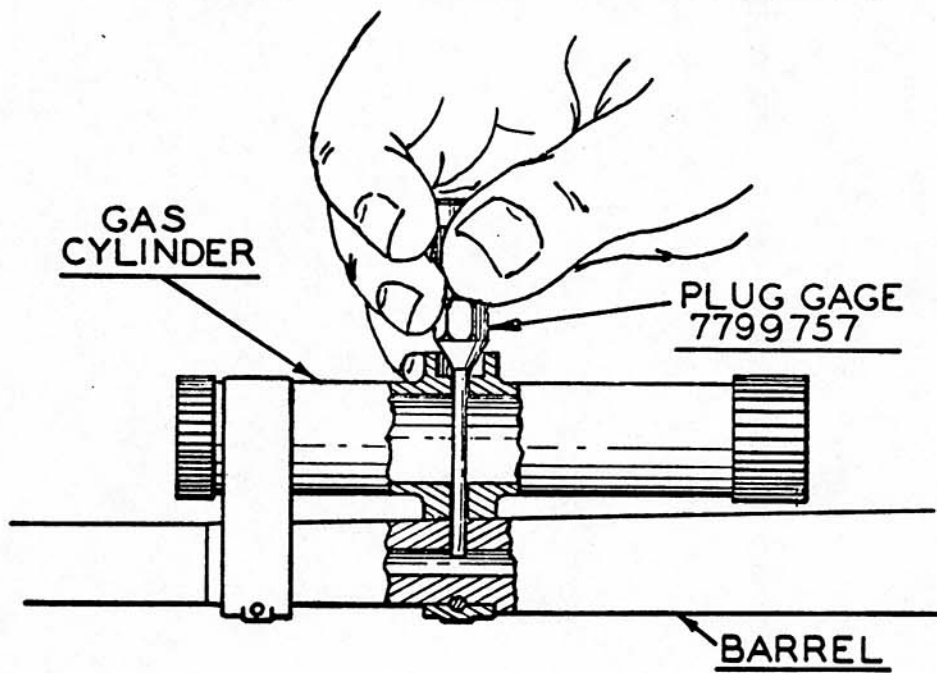
STANDARD DIAL DEPTH GAGE



Headspace Gaging Procedure

- Zero dial depth gage as shown in left view.
- Insert gage 7799754 into chamber, applying pressure to overcome spring load, and rotate to fully locked position.
- Flush pin of gage must be protruding from gage surface.
- Position dial depth gage as shown in right view.
- To be acceptable, flush pin of gage shall protrude a minimum of .0035 as indicated on dial depth gage.

CHECKING DIAMETER OF GAS PORT HOLE



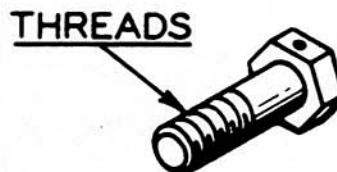
U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7792095
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Bolt, Machine, Aircraft
for Overhaul of the Machine Gun, 7.62MM, M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp.Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given the threads for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating or Cadmium Plating



*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

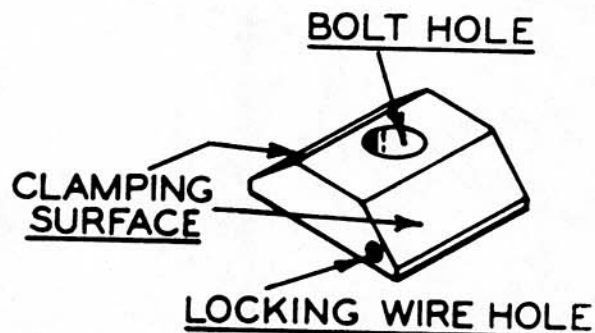
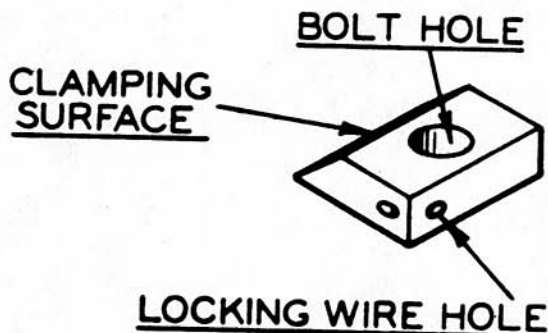
OIP-7792092
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Clamp, Rim Clenching
for Overhaul of the Machine Gun, 7.62MM, M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given bolt and lockwire holes and clamping surface as indicated in figure below, for burrs or mutilations.)	0.65	Visual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

NOTE: Both designs shown in figure below are acceptable.



*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.

U. S. ARMY
ARMY WEAPONS COMMAND
OVERHAUL INSPECTION PROCEDURE
for

OIP-7792091
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

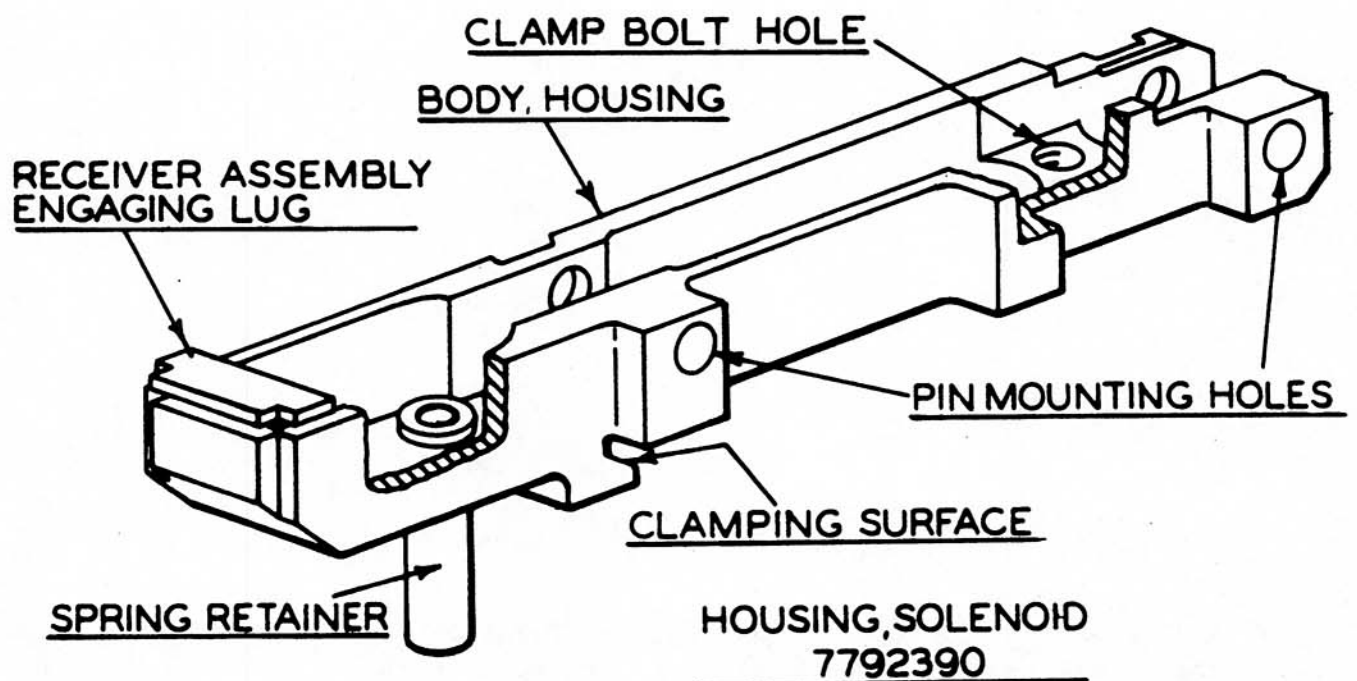
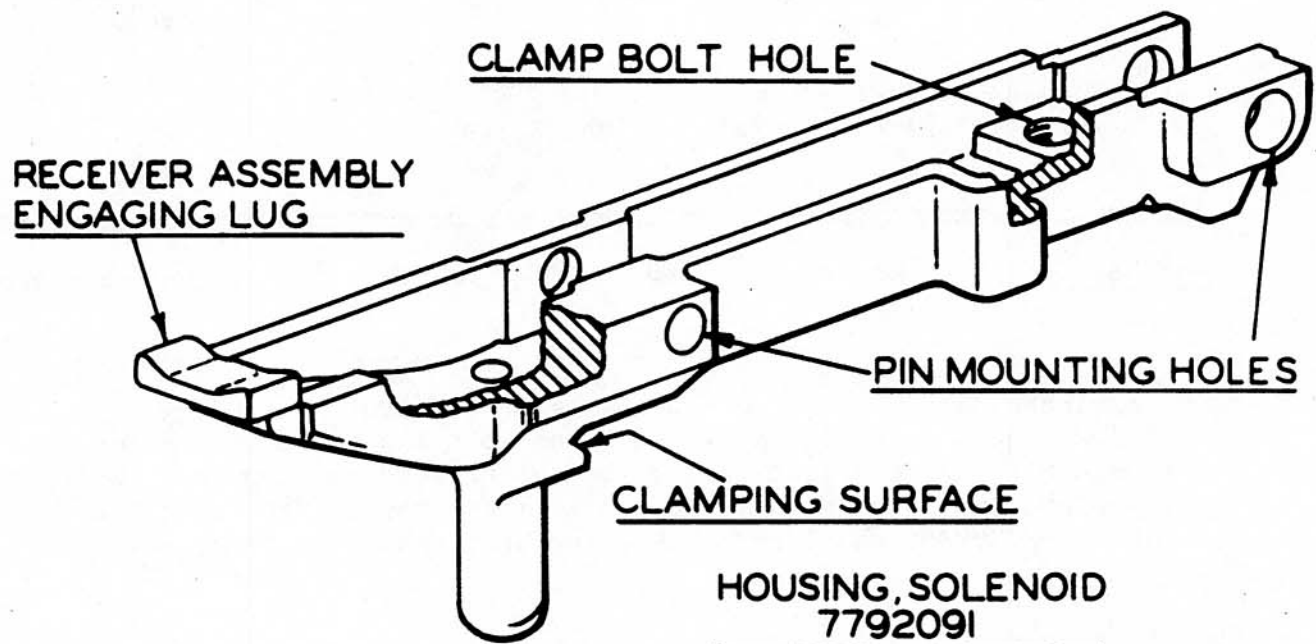
Item: Housing, Solenoid
for Overhaul of the Machine Gun, 7.62MM, M60C

EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Serviceability (Particular attention shall be given to the pin mounting holes, receiver Assy engaging lug, clamping surface and clamp bolt hole for cracks, burrs or mutilations as indicated in figure on page 2. Design 7792390 shall be checked for secureness of spring retainer in body.)	0.65	Visual-Manual	
2. Missing or Defective Protective Coating	1.5	Visual	Phosphate Coating

NOTE: Both designs shown in figures on page 2 are acceptable.

*AQL's are specified for final and verification sampling examination only.
Preliminary examination shall be performed on each piece.



U. S. ARMY
ARMY WEAPONS COMMAND
OVERHUAL INSPECTION PROCEDURE
for

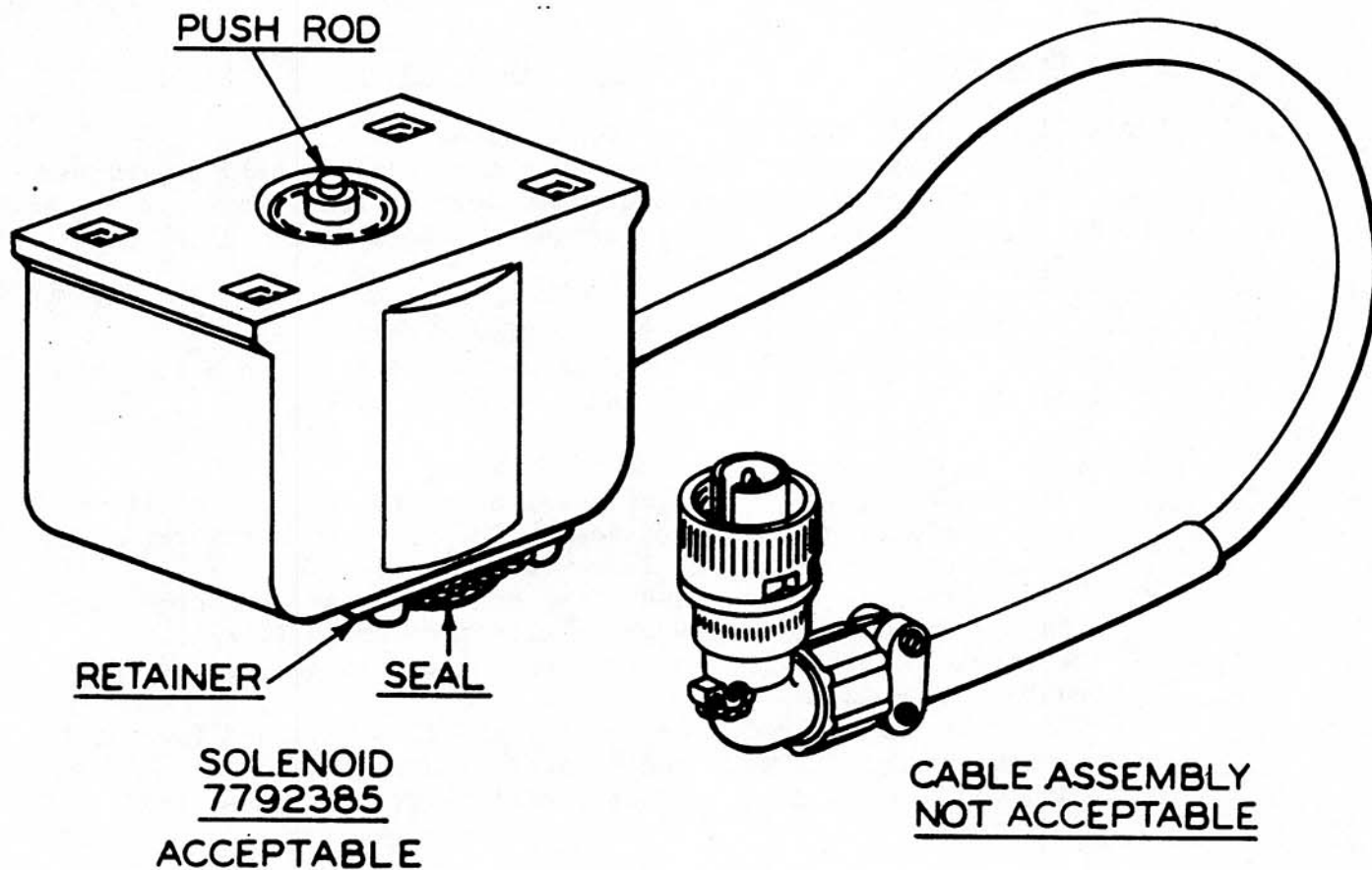
OIP-7791685
Approved: 28 May 65
Supplementary to:
USAWECOMDMWI 1005-224

Item: Solenoid
for Overhaul of the Machine Gun, 7.62MM, M60C

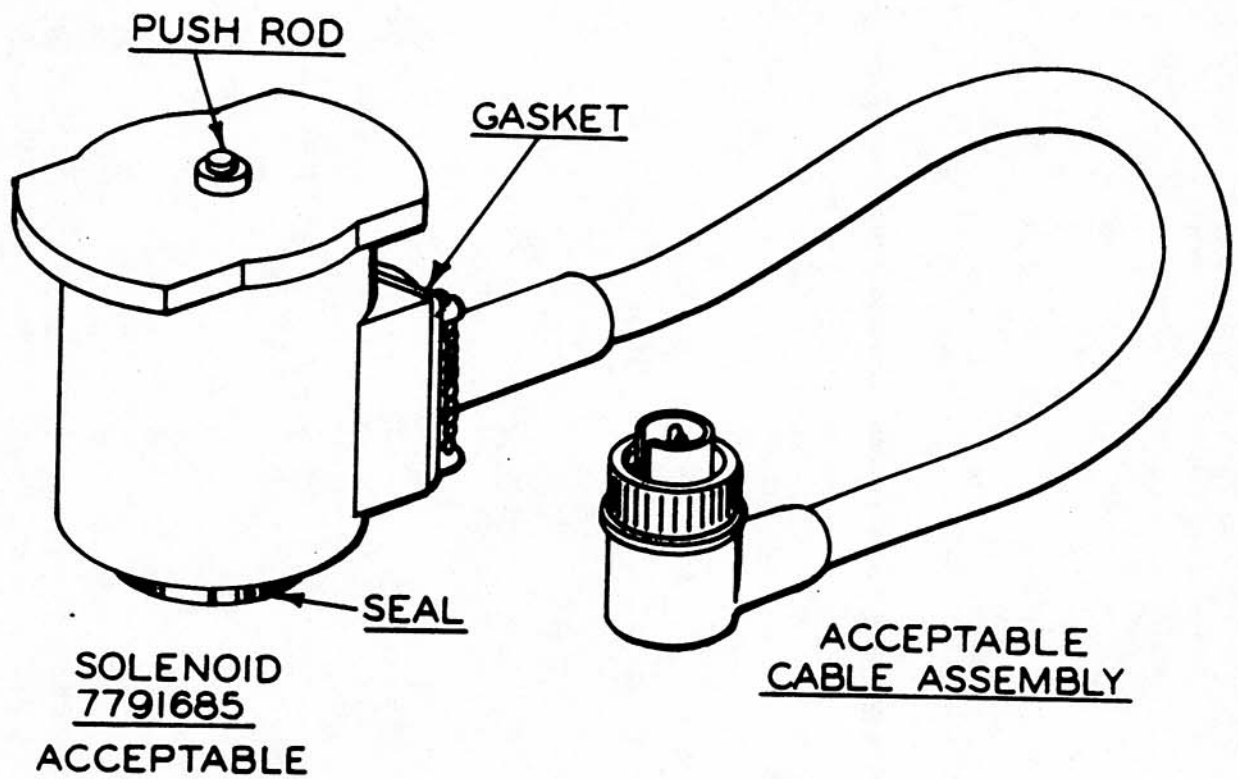
EXAMINATION. See Section 4 of USAWECOMDMWI 1005-224 for general provisions.

<u>Defect</u>	<u>*AQL</u>	<u>Insp. Method</u>	<u>Dimension</u>
1. Design Type (Cable Assembly)	0.65	Visual	
(Cable assemblies depicted with solenoid on page 2 shall be removed and replaced with cable assemblies depicted with solenoid on page 3. When replacing cable assemblies, rubber gasket shall be installed as shown in figure on page 3.)			
2. Serviceability	0.65	Visual-Manual	
(Particular attention shall be given to the areas noted below and depicted on figures on pages 2 and 3 as applicable.)			
a. Seals shall be free of cracks and tears.			
b. Push rod shall be capable of being moved to extended position by thumb pressure at bottom of seal. The push rod shall return under spring load when pressure is removed.			
c. Screws retaining cable assemblies on both types and screws on seal retainer of type 7792385 shall be securely lockwired.			
d. Cable assemblies shall be examined for cracks and breaks in rubber insulation.			
e. Connector plug of cable assemblies shall be examined for bent prongs, damaged threads and damaged prong housing.			
f. Push rod and mounting surfaces shall be free of burrs and mutilations.			
3. Electrical Continuity and Function	0.65	Std Elec Test Equip	
(The solenoid shall be energized using 20 volts DC causing push rod to be activated through its full range of travel. De-energizing of solenoid shall cause push rod to be returned to retracted position under spring load.)			

*AQL's are specified for final and verification sampling examination only. Preliminary examination shall be performed on each piece.



Cable assemblies depicted above shall be replaced in accordance with procedure specified in Section 6 of USAWECOMDMWI 1005-224.



PART V

INSPECTION EQUIPMENT LIST

REV SYM	REVISION DATE	LIST	PART	REV SYM	REVISION DATE	LIST	PART	CHARACTERISTIC	EQUIPMENT	ORIGINATOR	NUMBER	DATE REV	CODE
A								FIRING PIN PROTRUSION	FIRING PIN PROTRUSION	A	7274754 -	-	
								TARGETING AND ACCURACY	TEST FIXTURE	F	7273907 -	-	
								HEADSPACE (GUN ASSY USING GUN BOLT)	HEAD SPACE (SOLID PLUG)	D	7274746	-	
								PROOF, FUNCTION AND ENDURANCE FIRING	TEST FIXTURE DWG FOR BELT CLEARANCE	F	7273925 -	-	
								TRIGGER PULL	TRIGGER PULL	C	7273911 -	-	
								CYCLIC RATE OF FIRE	TIMER	D	7274758 -	-	
								NOT GO DIA, FIRING PIN HOLE (BOLT OIP-7269060)	PLAIN PLUG	D	7273920 -	-	
								HEADSPACE, MAX (BARREL ASSY W/PIVOT OIP-7269028)	HEADSPACE	-	7458598 -	-	
A								GO DIA, GAS PORT HOLE (BARREL ASSY W/PIVOT OIP-7269028)	SPECIAL GO PLUG	D	7799754	-	
A								IMPROPER PARTS (ROD ASSY, OPERATING OIP-7791597)	SPECIAL GO PLUG	A	7799757	-	
A										B	7799756	-	

THIS LIST APPLIES TO
GUN, MACH 7.62 MM M60
OVERHAUL PROGRAM ONLY

USAWECOMP-3

THIS LIST APPLIES TO:

AND IS COORDINATED WITH:

REV SYM	REVISION DATE	LIST	PART	REV SYM	REVISION DATE	LIST	PART
ORIG	28 FEB 64	30 DEC 57					
A4	22 OCT 64	30 AUG 63					

LIST OF INSPECTION EQUIPMENT FOR:

GUN, MACHINE, 7.62MM, M60

PREPARED *AL* REVIEWED *AL*
SUBMITTED
C. Caraccioli
APPROVED BY
J. V. Rowley

SPRINGFIELD ARMORY
U. S. ARMY
MATERIEL COMMAND

OVERHAUL
IEL J 7269100
SHEET 1 OF 1

PART VI

INSPECTION EQUIPMENT LIST

CHARACTERISTIC	EQUIPMENT	OR ASSY SIZE	NUMBER	QTY REQ	CODE
FIRING PIN PROTRUSION	FIRING PIN PROTRUSION	A	7274754	-	
TARGETING AND ACCURACY	TEST FIXTURE	F	11017822	-	
	TELESCOPE, BORESIGHT	C	7797808	-	
	MANDREL, EXPANDING	D	7796858	-	
HEADSPACE(GUN ASSY USING GUN BOLT)	HEAD SPACE (SOLID PLUG)	D	7274746	-	
PROOF, FUNCTION AND ENDURANCE FIRING	TEST FIXTURE COVER	F	11017821	-	
		F	7273975	-	
CYCLIC RATE OF FIRE	TIMER	D	7273920	-	
NOT GO DIA, FIRING PIN HOLE (BOLT OIP-7269060)	PLAIN PLUG	-	7458598	-	
HEADSPACE, MAX (BARREL SUB ASSY OIP-7792084)	HEADSPACE	D	7799754	-	
GO DIA, GAS PORT HOLE (BARREL SUB ASSY OIP-7792084)	SPECIAL GO PLUG	A	7799757	-	
IMPROPER PARTS (ROD ASSY, OPERATING OIP-7791597)	SPECIAL GO PLUG	B	7799756	-	

THIS LIST APPLIES TO
GUN, MACH 7.62 MM M60 C
OVERHAUL PROGRAM ONLY

USAWECOMPD-3

THIS LIST APPLIES TO:						AND IS COORDINATED WITH:							
REV SYM	REVISION DATE		REV SYM	REVISION DATE		LIST OF INSPECTION EQUIPMENT FOR: GUN, MACHINE, 7.62MM, M60C							
	LIST	PART		LIST	PART								
ORIG	30OCT64	14 Nov 63				PREPARED <i>NL</i>		REVIEWED <i>NL</i>		SPRINGFIELD ARMORY U. S. ARMY MATERIEL COMMAND			
						SUBMITTED <i>C Caracelli</i>							
						APPROVED BY <i>J. V. Rowley</i>				OVERHAUL F 7792090 IEL SHEET 1 OF 1			

PART VII

1. Reports of Final Inspection stating results of final examination and functioning firing, targeting, and accuracy tests, will be prepared on a monthly basis, in the prescribed format illustrated in Section 2, Figure 1. (Exempt Report, Paragraph 39u, AR 335-15.)

1.1 Reports of all Small Arms Weapons Reliability Tests will be prepared on a monthly basis, in the prescribed format illustrated in Section 2, Figure 2. (Exempt Report, Paragraph 39u, AR 335-15.)

1.2 Reports set forth in paragraphs 1 and 1.1 above will be submitted, in triplicate, to the Commanding General, U. S. Army Weapons Command, ATTN: AMSWE-QA, Rock Island, Illinois. One (1) copy will be furnished Commanding Officer, Springfield Armory, ATTN: SWESP-RES, Springfield, Massachusetts 01101. Reports should arrive not later than five (5) working days following the end of the month.

FINAL INSPECTION REPORT										MAJOR ITEM															
										REPORTED BY					WEEK END.										
FUNCTION FIRING																									
MALFUNCTION					REJECTED NO. %		MALFUNCTION					REJECTED NO. %		AVE. RDS PER GUN			CODE (OVER)								
														AMM. LOT NOS.											
														FUNCTION FIRING SUMM.											
														NEW REP. TOTAL											
														GUNS FIRED NO. % ACCEPT.											
TARGET INSPECTION																									
REJECTIONS (OVER SPECIFICATIONS) INCHES OFF															AMM. LOT NOS.										
															AMM. QUALITY										
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	TARGET INSP. SUMM.									
HIGH																									
LOW																									
RIGHT																									
LEFT																									
ACCURACY INSPECTION																									
REJECTIONS: SIZE OF GROUP, INCHES (OVER SPECIFICATIONS)															ACCURACY INSP. SUMM.										
															NEW REP. TOTAL										
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	X										
FINAL INSPECTION																									
CAUSE OF REJECT.					REJECTED NO. %		CAUSE OF REJECT.					REJECTED NO. %		CAUSE OF REJECT.					REJECTED NO. %						
																					FINAL INSP. SUMM.				
																					NEW REP. TOTAL				
																					NO. IN-SPECT. NO. % ACCEPT.				

PREScribed FORMAT FOR SUBMISSION OF REPORT OF FINAL INSPECTION

FIGURE 1

[illegible]

PREScribed FORMAT FOR SUBMISSION OF REPORT OF SMALL ARMS WEAPONS
RELIABILITY FIRING TEST

FIGURE 2